

D1002309

Manifold-Cryo Baffle Weldment Assembly - parts and quantities:

	<u>Part Number</u>	<u>Description</u>	<u>Rev</u>	<u>Qty</u>
1	D0902619	INNER SEGMENT, RIGHT	v1	1
2	D0902620	RADIAL SEGMENT, BOTTOM	v1	1
3	D0902621	BAFFLE BRACKET	v1	6
4	D0902622	INNER SEGMENT, LEFT	v1	1
5	D0902623	INNER SEGMENT, BOTTOM	v1	1
6	D0902657	HALF FACE PLATE	v1	2
7	D1000536	BRACE BRACKET	v1	4
8	D1000558	RADIAL SEGMENT, LEFT	v1	1
9	D1000559	RADIAL SEGMENT, RIGHT	v1	1
10	D1000570	CYLINDER	v1	1
11	D1000572	BRACE	v1	2 (To be provided by LIGO)
12	D1001018	SCRAPER BLADE	v1	1
13	D1001073	RADIAL ATTACHMENT	v1	3

Manifold-Cryo Baffle Weldment Assy- subassemblies and quantities:

(BOM for subassemblies listed on drawings)

	<u>Part Number</u>	<u>Description</u>	<u>Rev</u>	<u>Qty</u>
1	D0902654	WELDMENT SUBASSY, RIGHT	v1	1
2	D0902655	WELDMENT SUBASSY, BOTTOM	v1	1
3	D0902656	WELDMENT SUBASSY, LEFT	v1	1
4	D1001348	CYLINDER SCRAPER ASSY	v1	1

Manifold-Cryo Baffle Weldment - Drawing Tree

D1002061 WELDMENT ASSY(1) [BOM#E1000359](#)

D0902654 WELDMENT SUBASSY, RIGHT (1) [BOM#E1000091](#)

D0902619 INNER SEGMENT, RIGHT (1)

D1000559 RADIAL SEGMENT, RIGHT (1)

D0902621 BAFFLE BRACKET (2)

D1000536 BRACE BRACKET(1)

D1001073 RADIAL ATTACHMENT (1)

D0902655 WELDMENT SUBASSY, BOTTOM (1) [BOM#E1000085](#)

D0902623 INNER SEGMENT, BOTTOM (1)

D0902620 RADIAL SEGMENT, BOTTOM (1)

D0902621 BAFFLE BRACKET (2)

D1001073 RADIAL ATTACHMENT (1)

D0902656 WELDMENT SUBASSY, LEFT (1) [BOM#E1000090](#)

D0902622 INNER SEGMENT, LEFT (1)

D1000558 RADIAL SEGMENT, LEFT (1)

D0902621 BAFFLE BRACKET (2)

D1000536 BRACE BRACKET (1)

D1001073 RADIAL ATTACHMENT (1)

~~D1000572 BRACE (2) (To be provided by LIGO)~~

D1001348 CYLINDER SCRAPER ASSY (1) [BOM#E1000367](#)

D1000570 CYLINDER (1)

D1001018 SCRAPER BLADE (1)

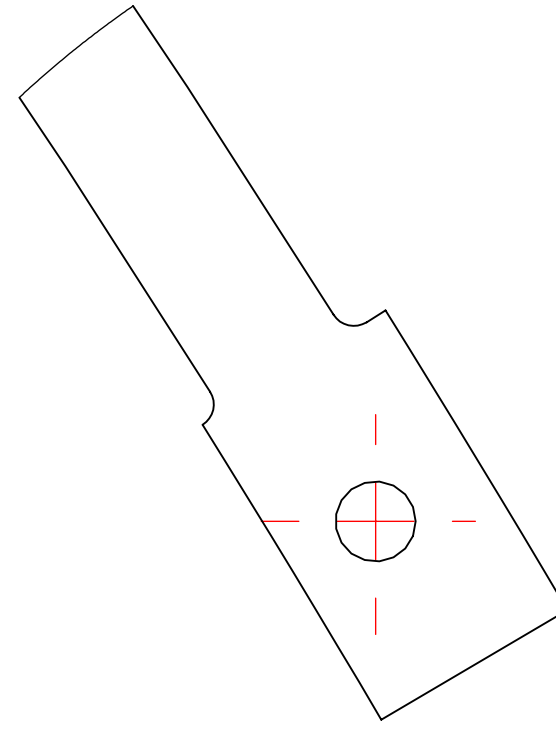
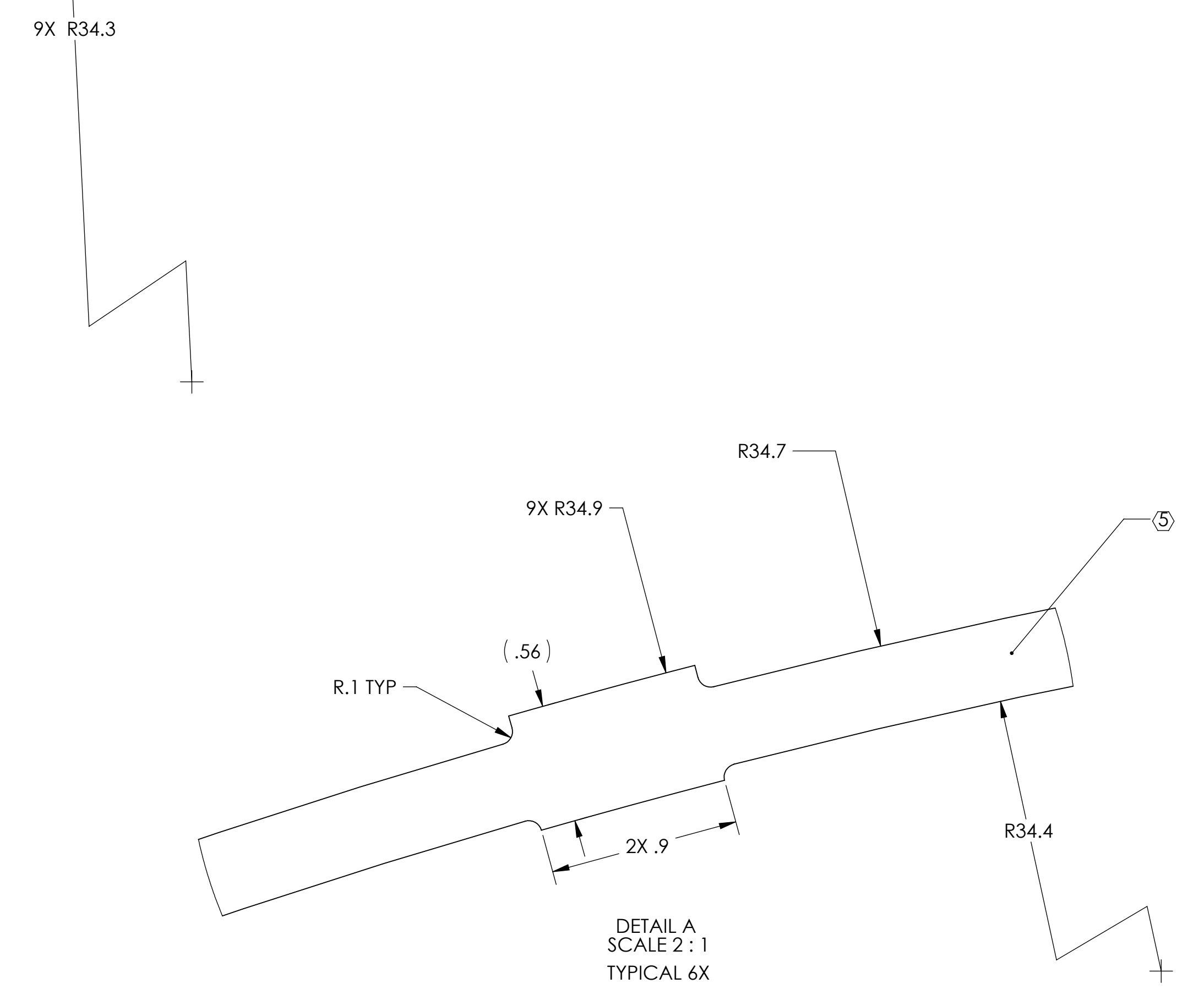
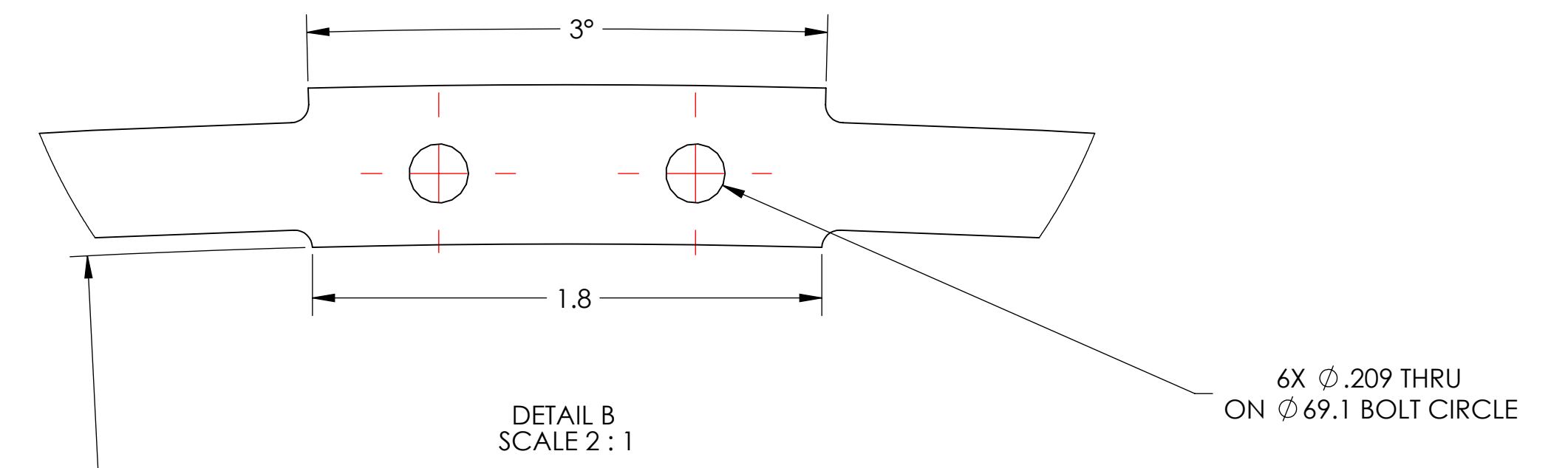
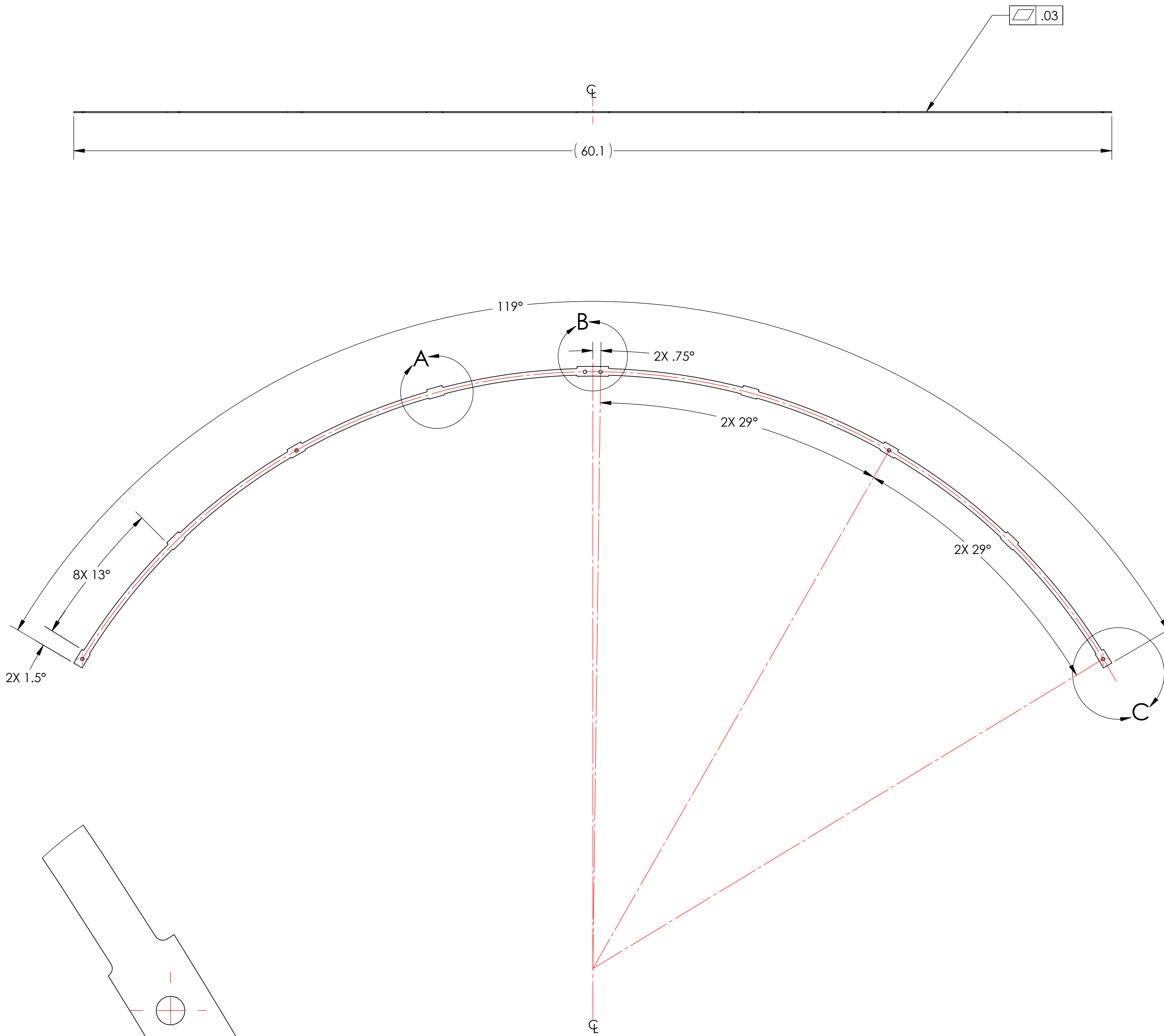
D1000536 BRACE BRACKET (2)

D0902657 HALF FACE PLATE (2)

NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

⑥ AS RECEIVED MACHINE FINISH

REV.	DATE	DCN #	DRAWING TREE #
V1	08 SEP 2010	E1000360	E1000085
-	-	-	E1000090
-	-	-	E1000091



THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE NEXT ASSEMBLY FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
MATERIAL	FINISH	NEXT ASSY	
14GA A424 TYPE I STEEL	⑥	D0902655, D0902654, D0902656	
ANGULAR ± 1.0°			

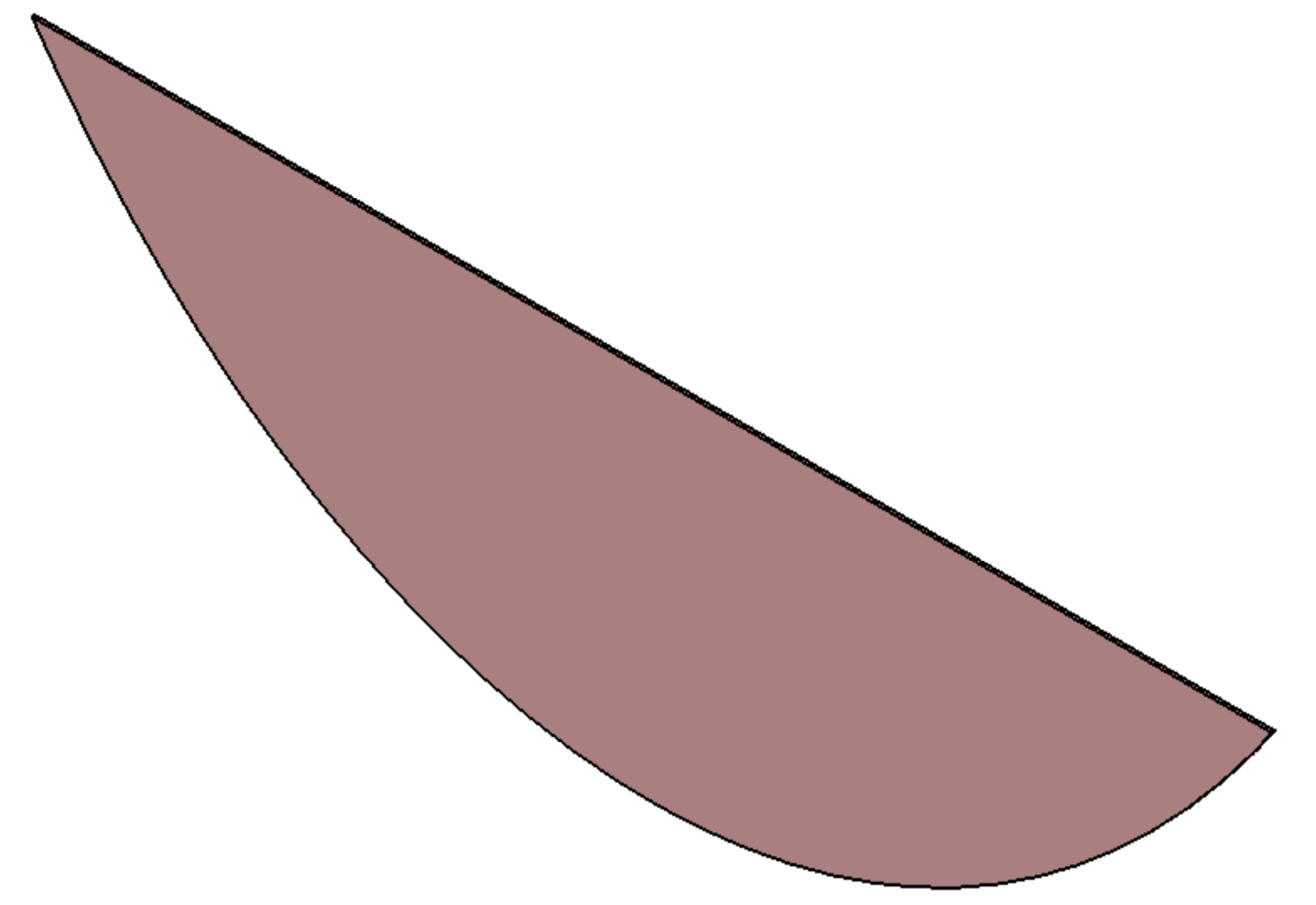
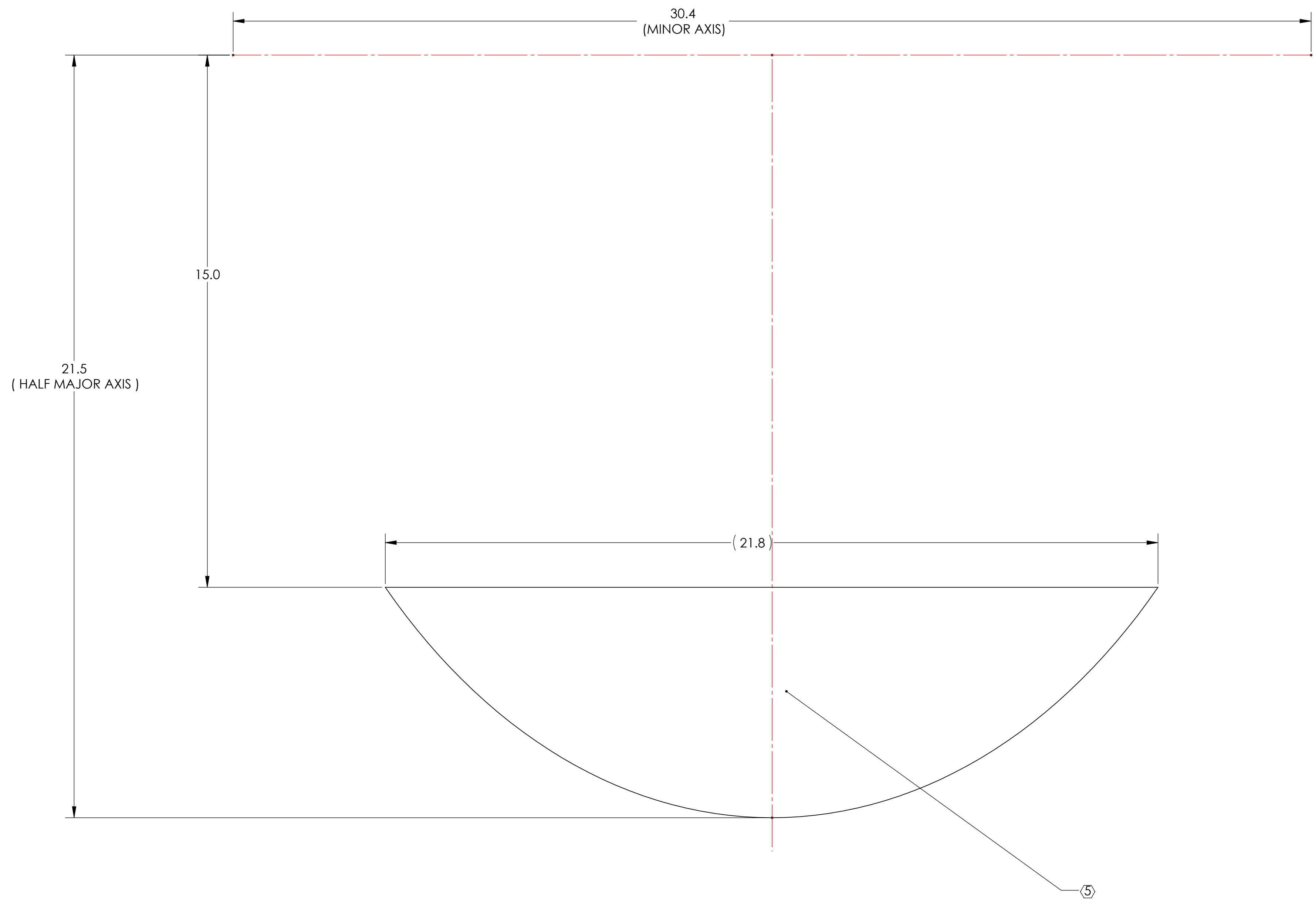
CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		RADIAL ATTACHMENT NUT PLATE	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	AOS	DESIGNER	H. KELMAN
				DRAFTER	TQ. NGUYEN
				CHECKER	M. SMITH
				APPROVAL	D. COYNE
DATE	6 APRIL 2010	SIZE	D	DWG. NO.	D1001073
DATE	17 AUG 2010	SCALE	1:4	PROJECTION	
REV.	V1	SHEET 1 OF 1			

D1001073.dwg, Weld, Nut, Plate, PART FDM REV: X01.3, DRAWING FDM REV: X-006

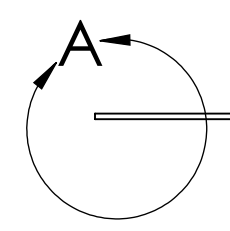
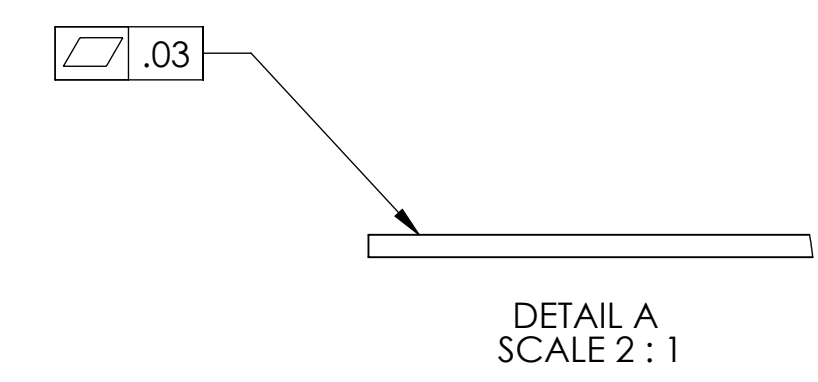
NOTES CONTINUED:
 (5) SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

(6) AS RECEIVED MACHINE FINISH

REV.	DATE	DCN #	DRAWING TREE #
V1	08 SEP 2010	E1000360	E1000367
-	-	-	-
-	-	-	-



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D1001348 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .X ±.1 .XX ±.06 .XXX ±.010		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM ADVANCED LIGO SUB-SYSTEM AOS		ELLIPSE SCRAPER BLADE	
ANGULAR ± 1.0°		MATERIAL 14GA A424 TYPE I STEEL FINISH (6)		NEXT ASSY D1001348		DESIGNER H. KELMAN	
						DRAFTER TQ. NGUYEN	
						CHECKER M. SMITH	
						APPROVAL D. COYNE	
						SIZE DWG. NO. D1001018	
						REV. V1	
						SCALE: 1:2 PROJECTION: SHEET 1 OF 1	

D1001018.dwg_Monitichl_Crv_Baffle_Scraper_Blade_PART.PDM REV.X-004.DRAWING.PDM REV.X-008

8 7 6 5 4 3 2 1

NOTES CONTINUED:

⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. A VIBRATORY TOOL MAY BE USED.

REV.	DATE	DCN #	DRAWING TREE #
V1	20 MAY 2010	E1000360	-
-	-	-	-
-	-	-	-

D

D

C

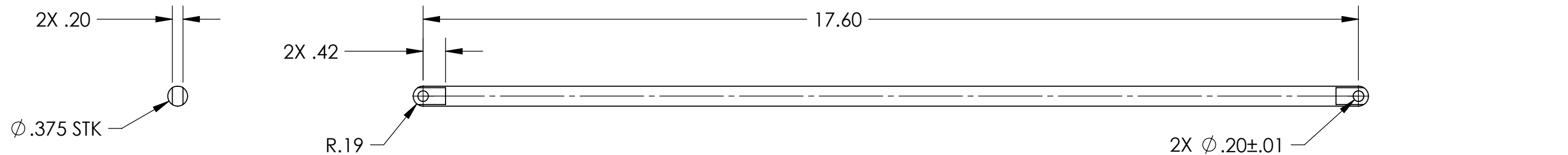
C

B

B

A

A



D1000572_Manifold_Cryo_Baffle_Square_Brace, PART PDM REV: X-004, DRAWING PDM REV: X-000

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)				LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
DIMENSIONS ARE IN INCHES				ADVANCED LIGO		MANIFOLD-CRYO BAFFLE BRACE	
TOLERANCES: .XX ± .03 .XXX ± .010				SUB-SYSTEM AOS		DESIGNER H. KELMAN 18 MAY 2010	
ANGULAR ± 1.0°				NEXT ASSY D1001348		SIZE DWG. NO. B D1000572	
MATERIAL 304, 316 OR 302 SSSL				FINISH 32		REV. v1	
				SCALE: 1:4		PROJECTION: SHEET 1 OF 1	

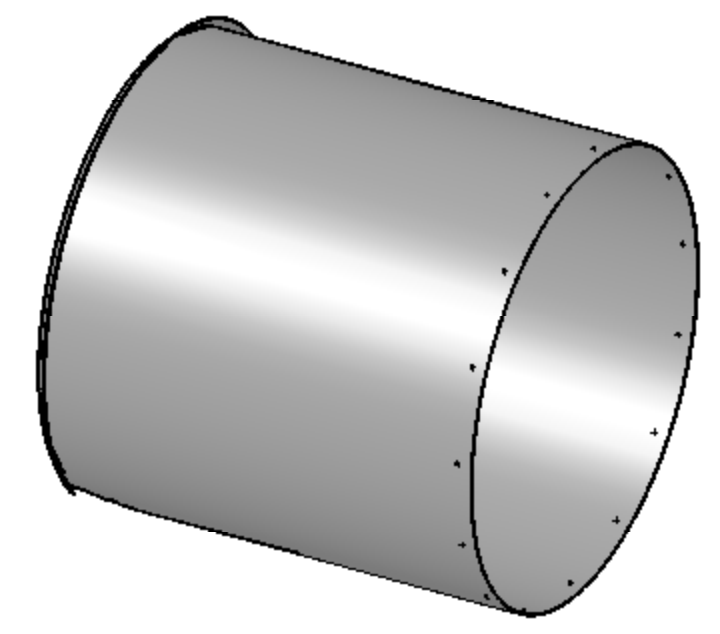
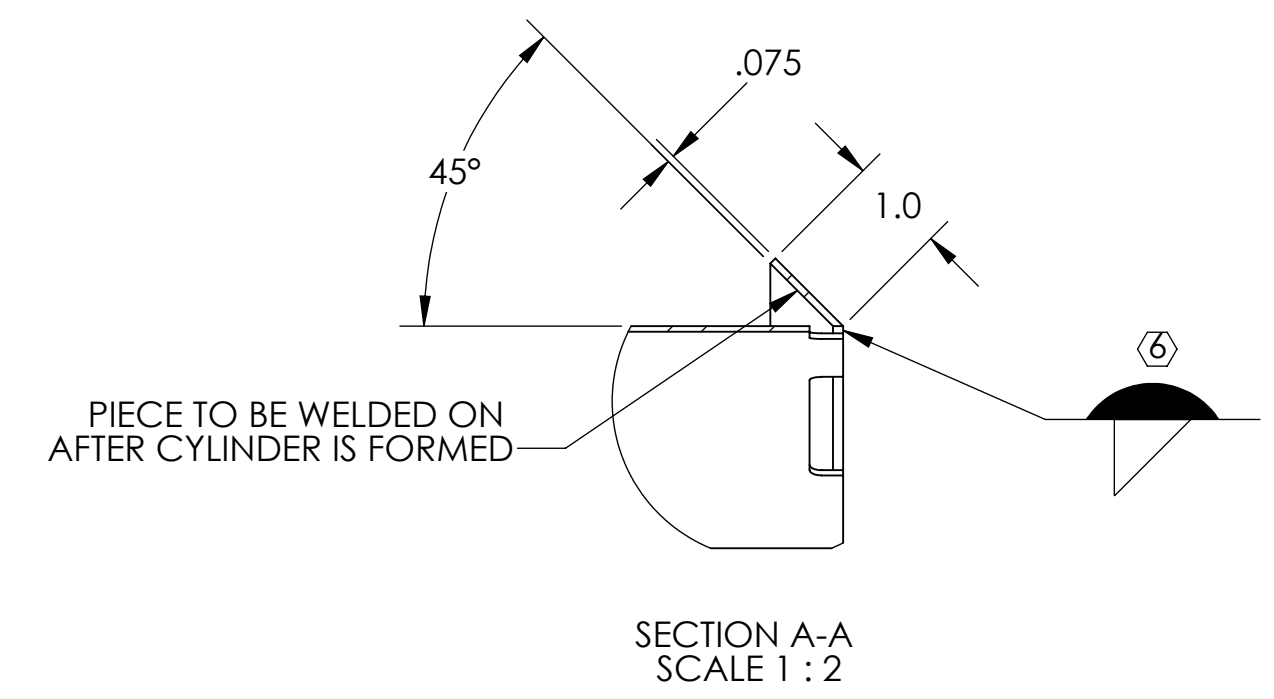
8 7 6 5 4 3 2 1

NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
 EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

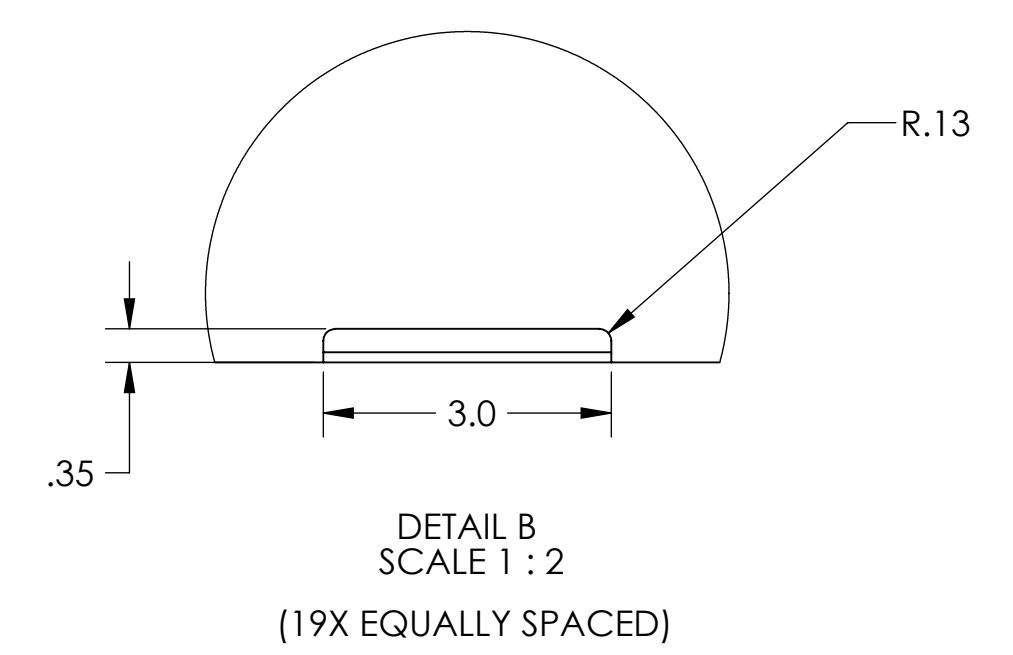
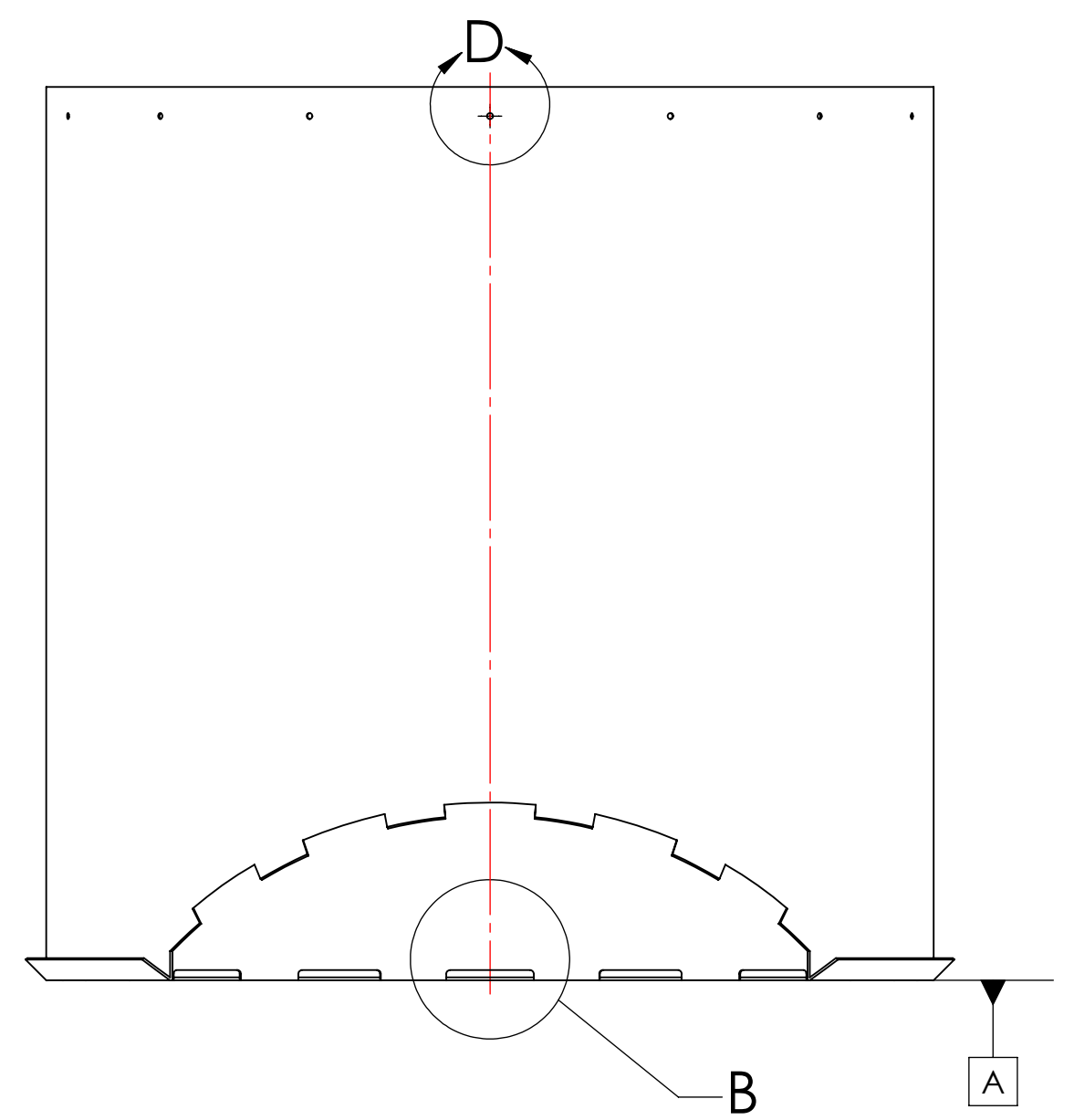
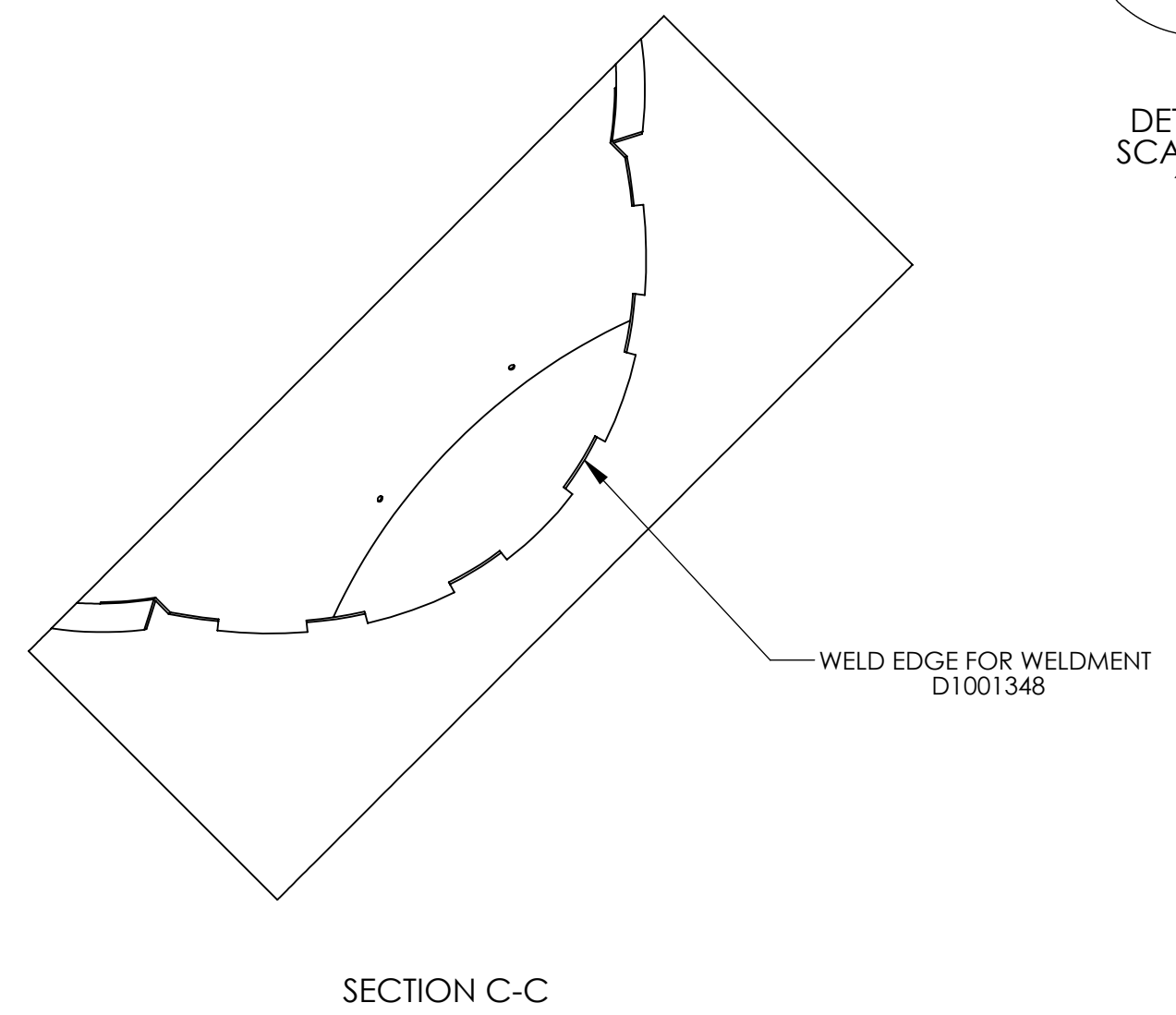
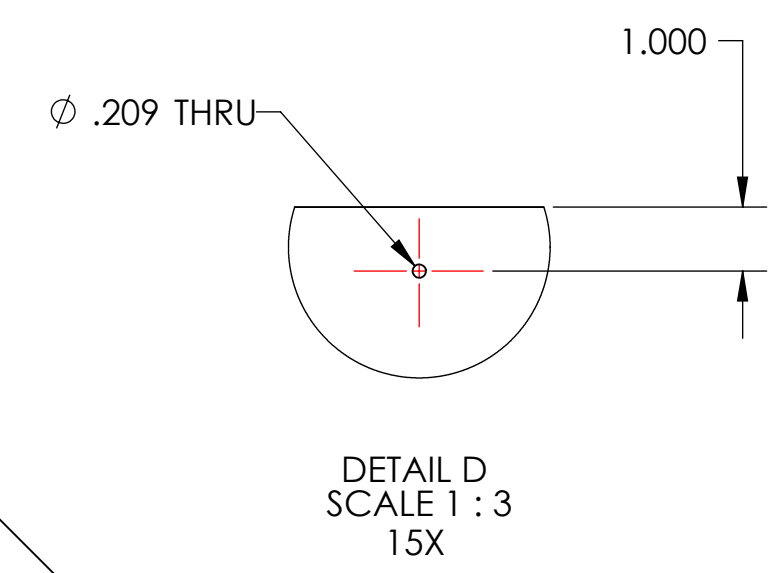
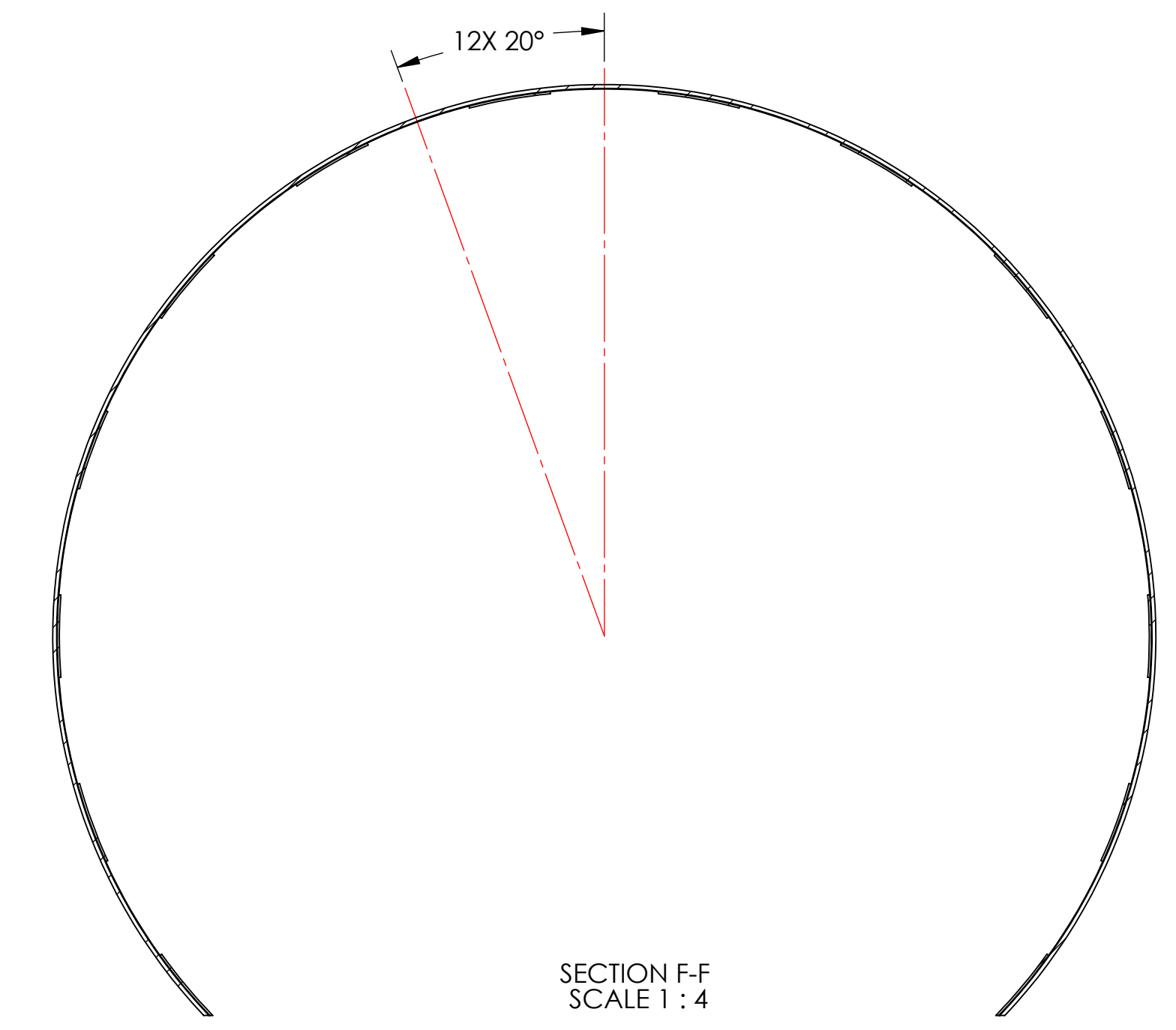
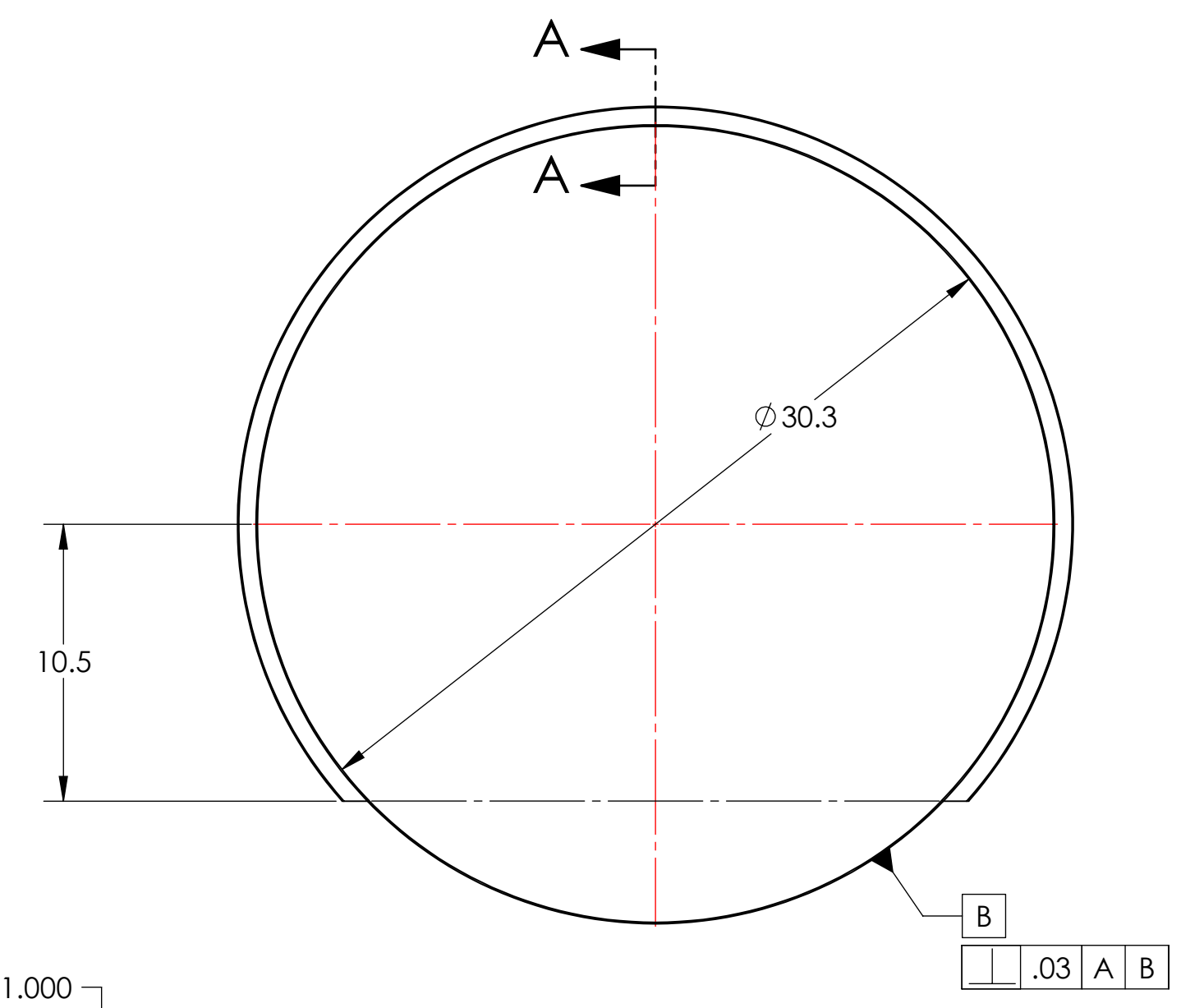
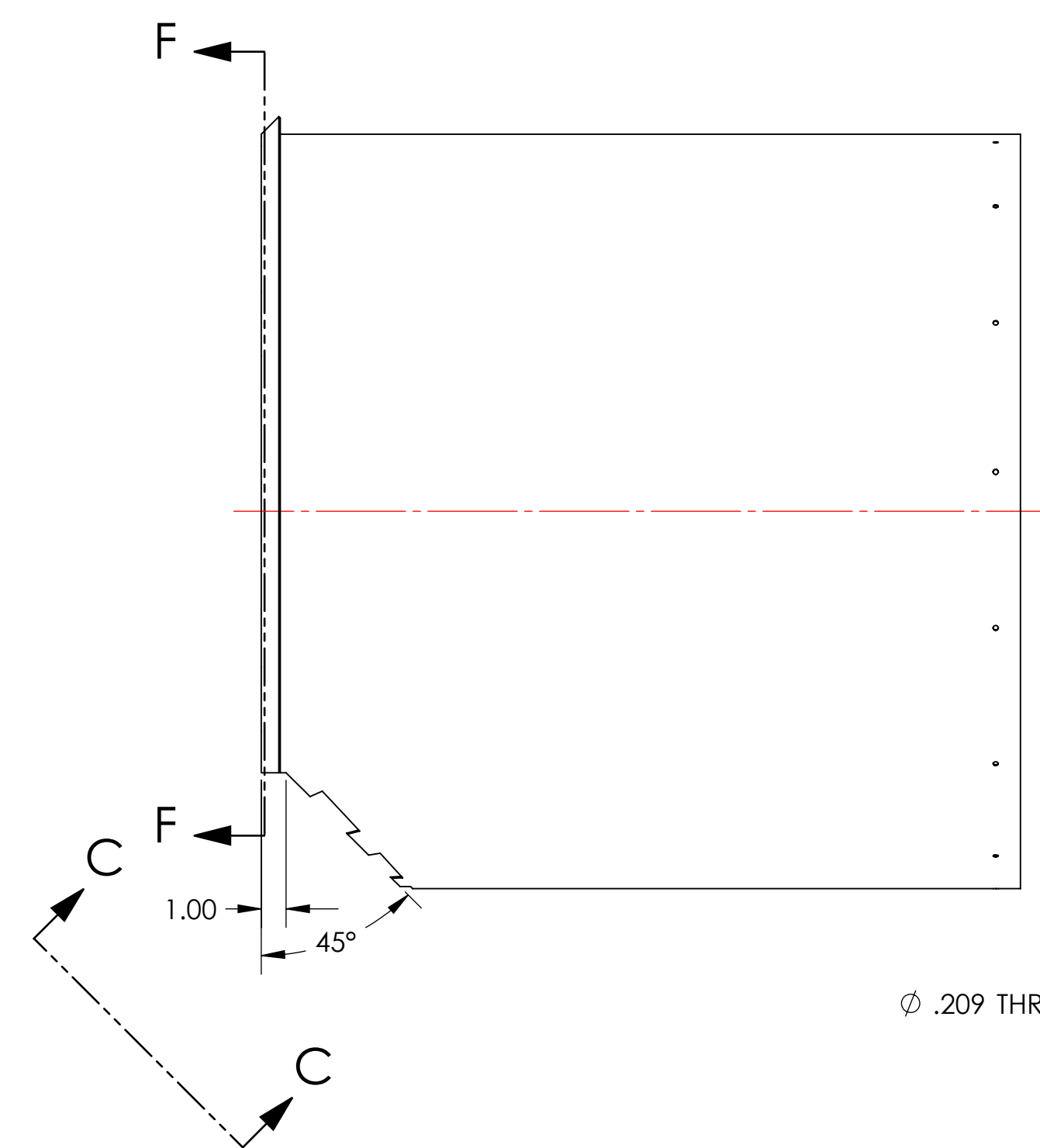
⑥ FILLET WELD WHERE RING AND CYLINDER MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048

⑦ AS RECEIVED MACHINE FINISH

REV.	DATE	DCN #	DRAWING TREE #
V1	07 SEP 2010	E1000360	E1000367



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



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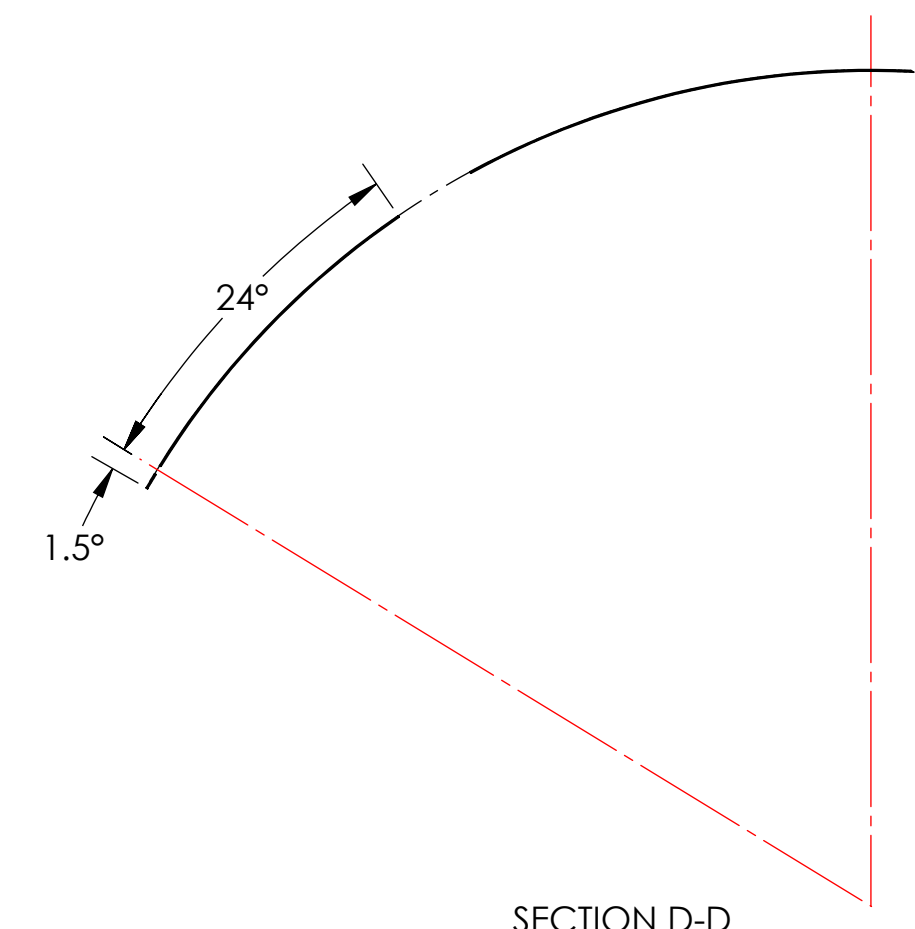
DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME					
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM ADVANCED LIGO		MANIFOLD-CRYO BAFFLE CYLINDER					
ANGULAR ± 1.0°		MATERIAL 18GA A424 TYPE I STEEL		SUB-SYSTEM AOS		DESIGNER H. KELMAN		SIZE D		DWG. NO. D1000570	
		FINISH ⑦		NEXT ASSY D1001348		DRAFTER TQ. NGUYEN		CHECKER M. SMITH		REV. v1	
						APPROVAL D. COYNE		SCALE: 1:6		PROJECTION:	
										SHEET 1 OF 1	

D1000570.dwg - Manifold_Cryo_Baffle_Cylinder_Parts - PART FDM REV: X014 - DRAWING FDM REV: X005

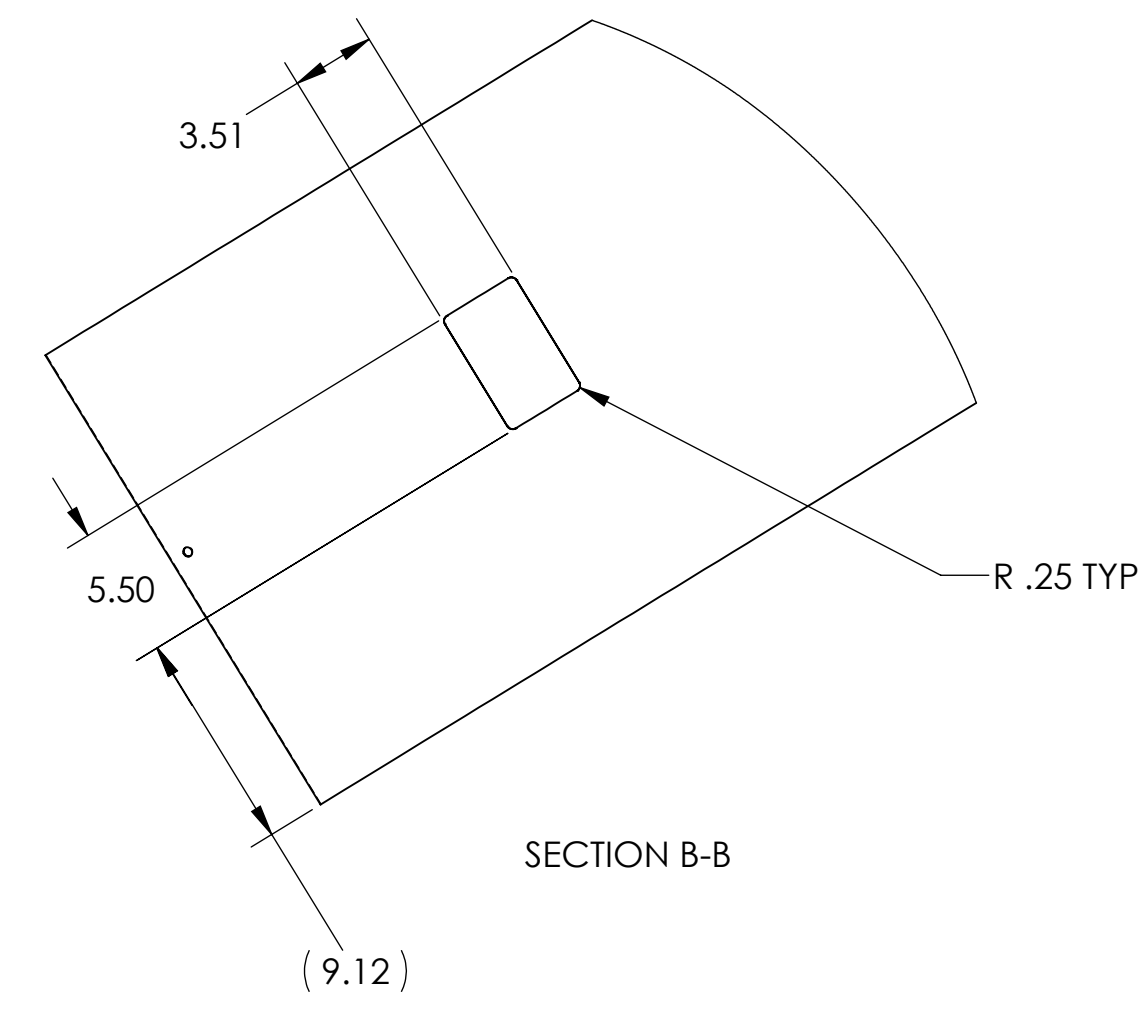
NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

⑥ MATERIAL AS RECEIVED MACHINE FINISH

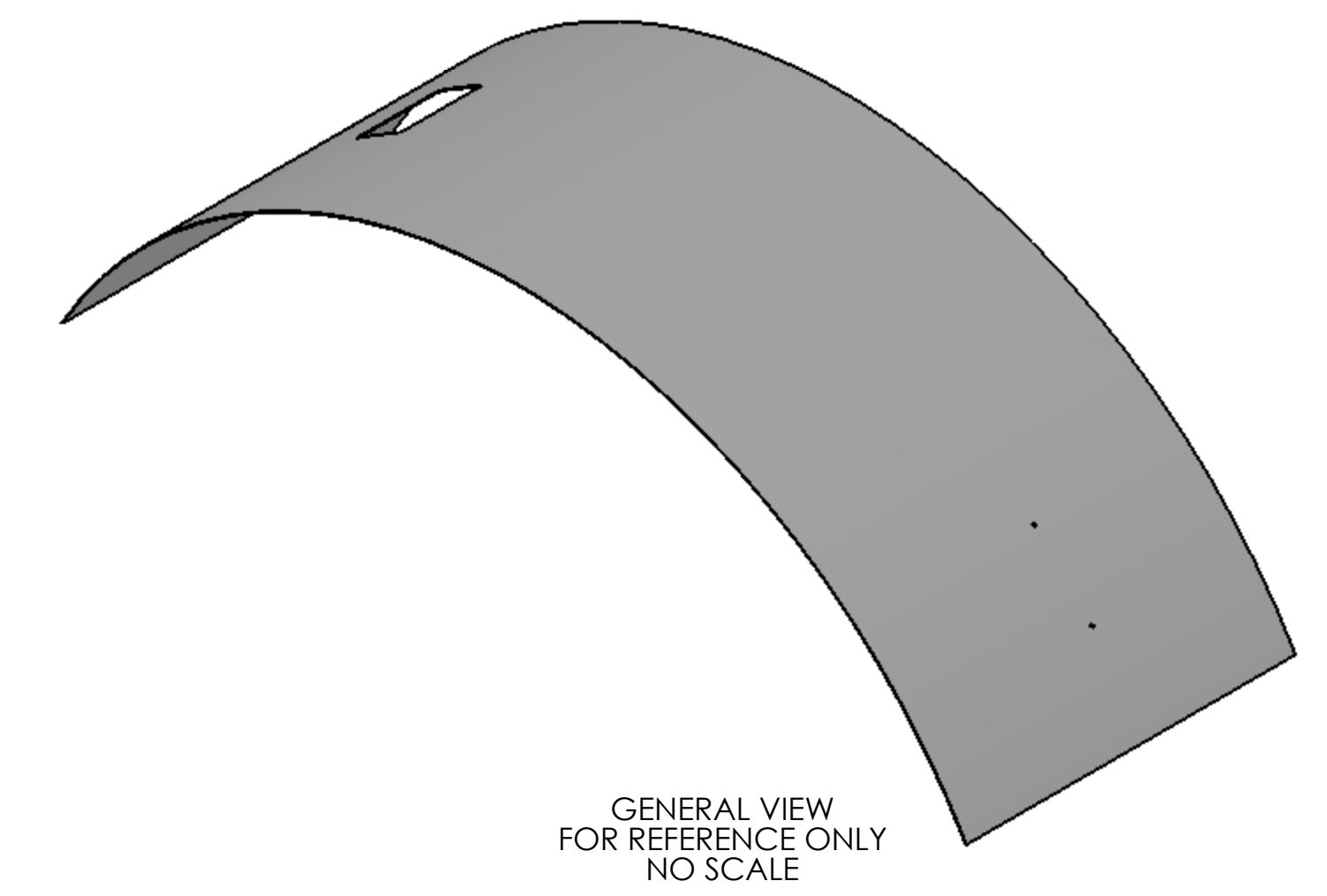
REV.	DATE	DCN #	DRAWING TREE #
v1	03 SEP 2010	E1000360	E1000091
-	-	-	-
-	-	-	-



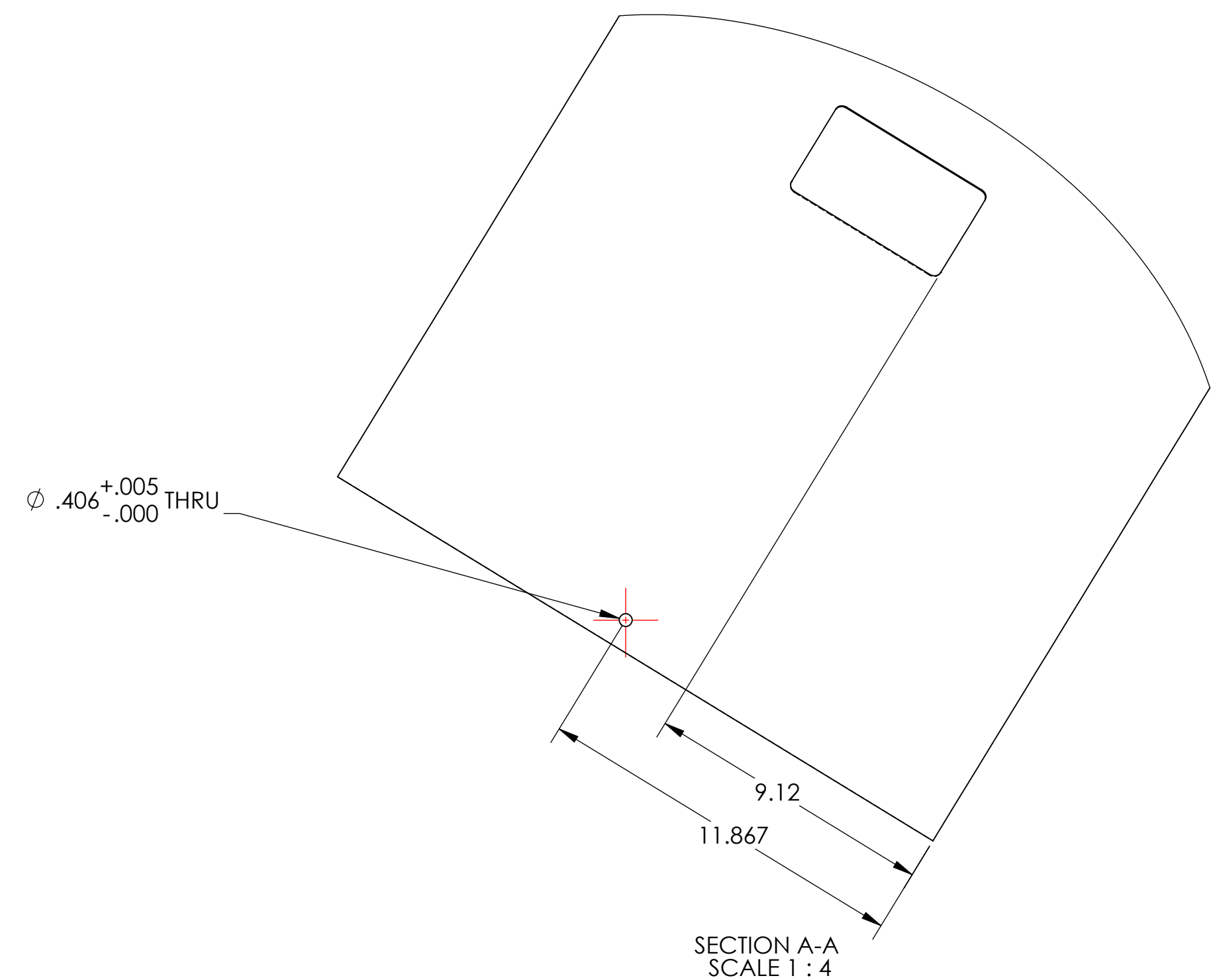
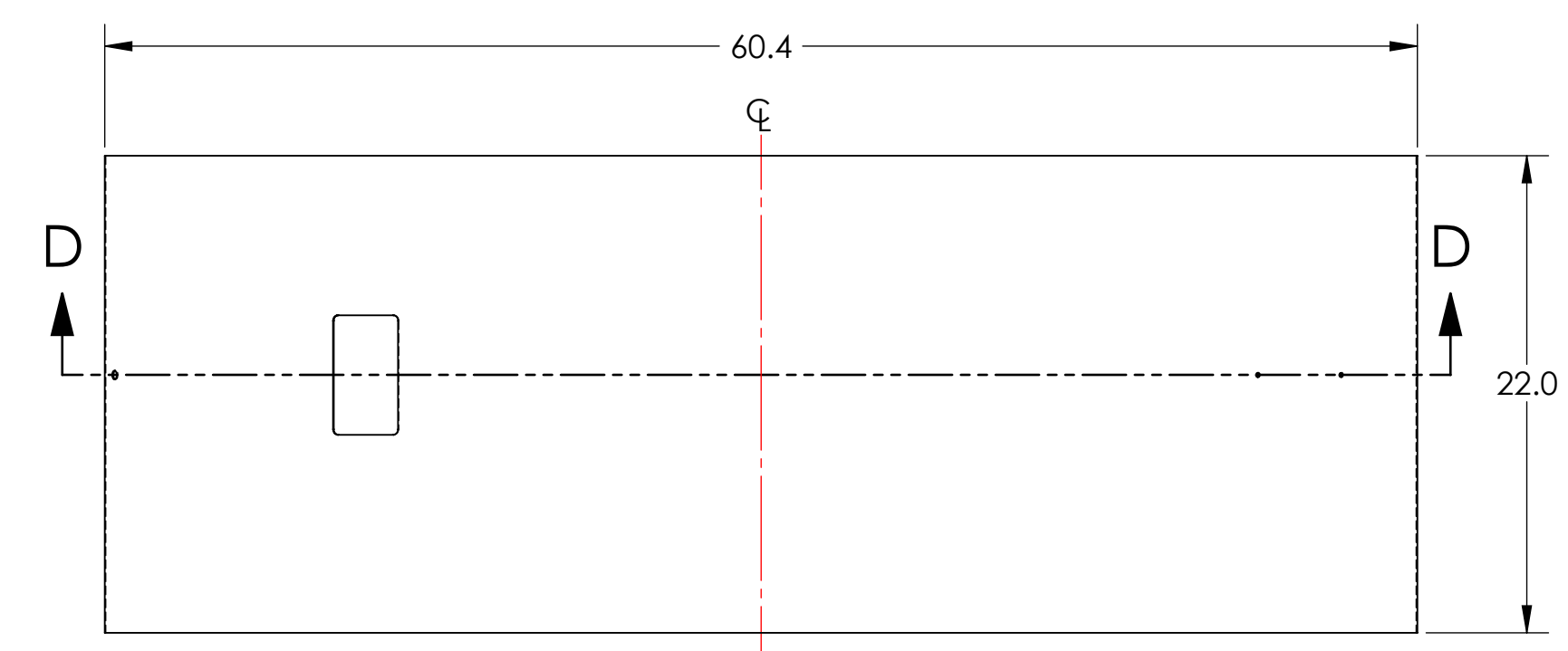
SECTION D-D



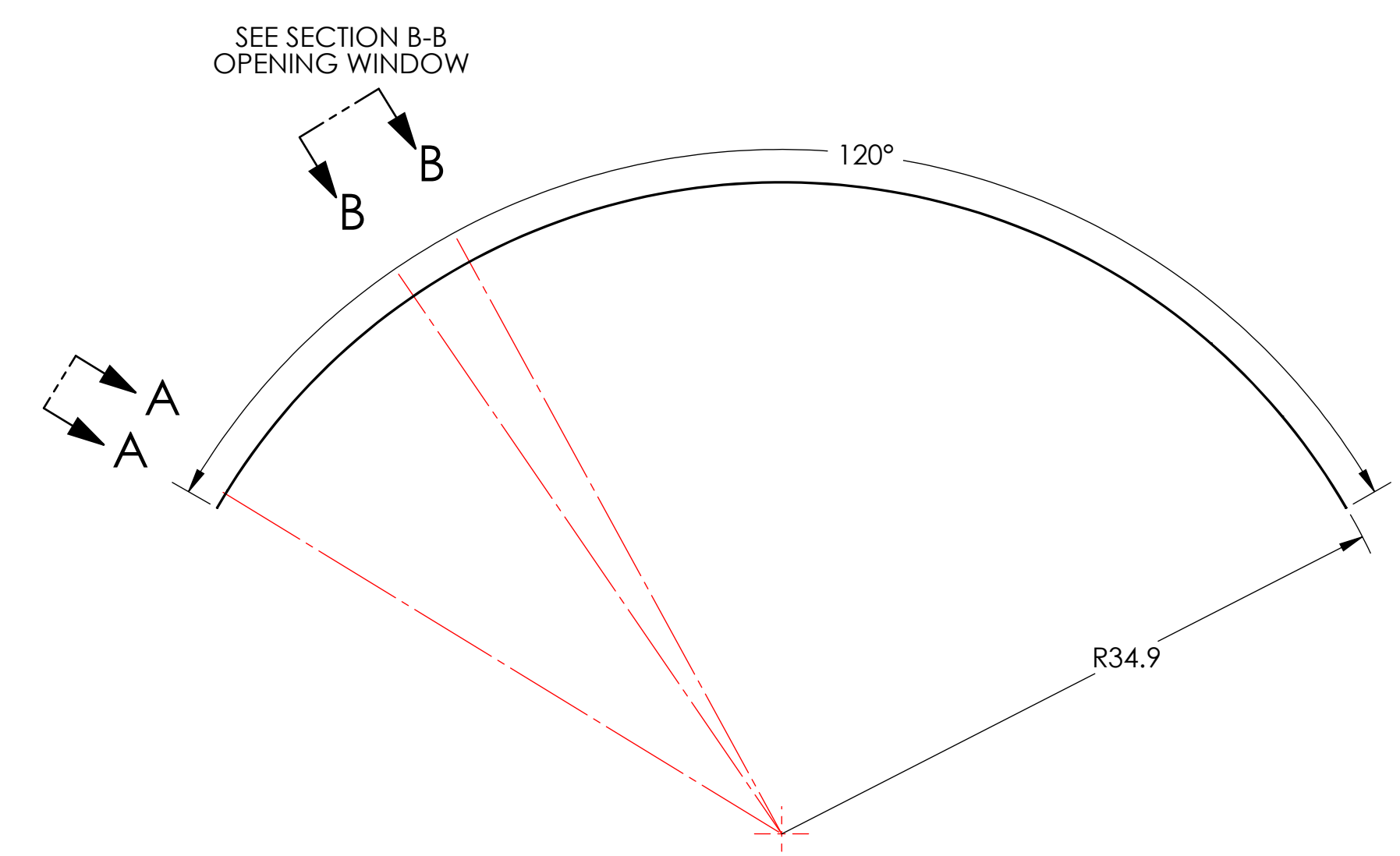
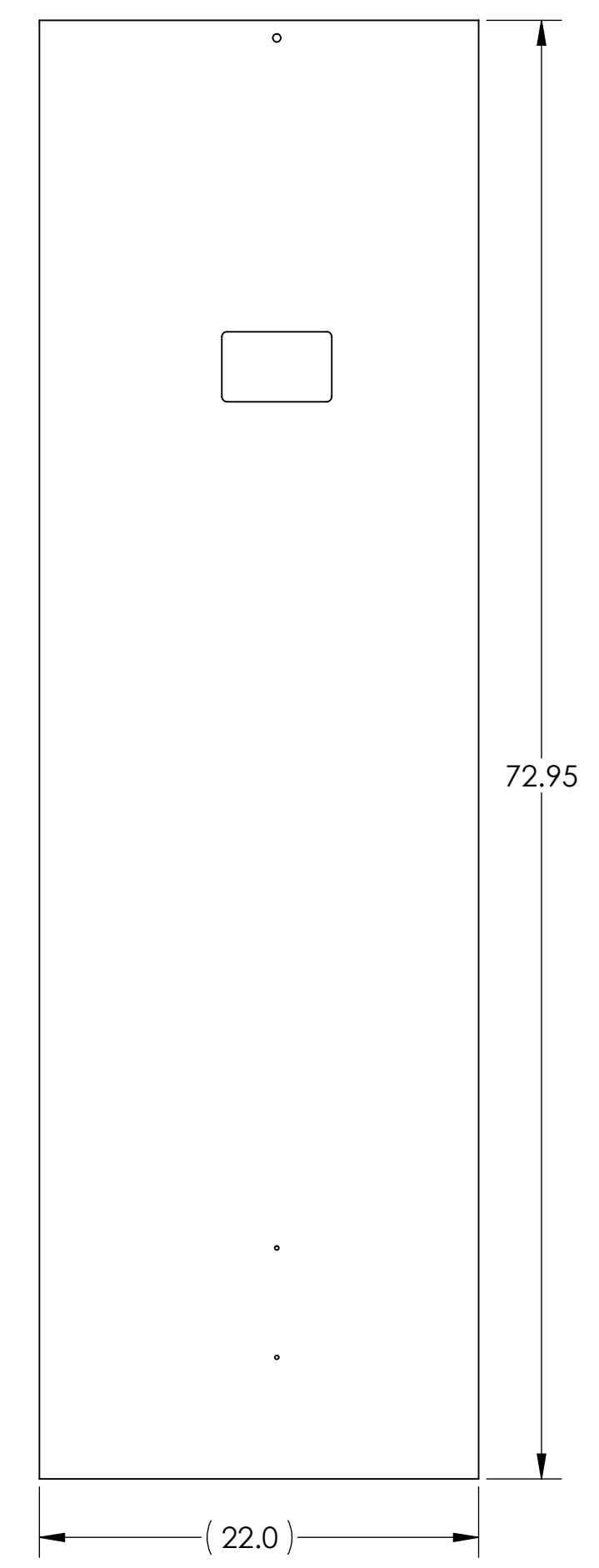
SECTION B-B



GENERAL VIEW FOR REFERENCE ONLY NO SCALE



SECTION A-A SCALE 1:4



SEE SECTION B-B OPENING WINDOW

THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902654 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

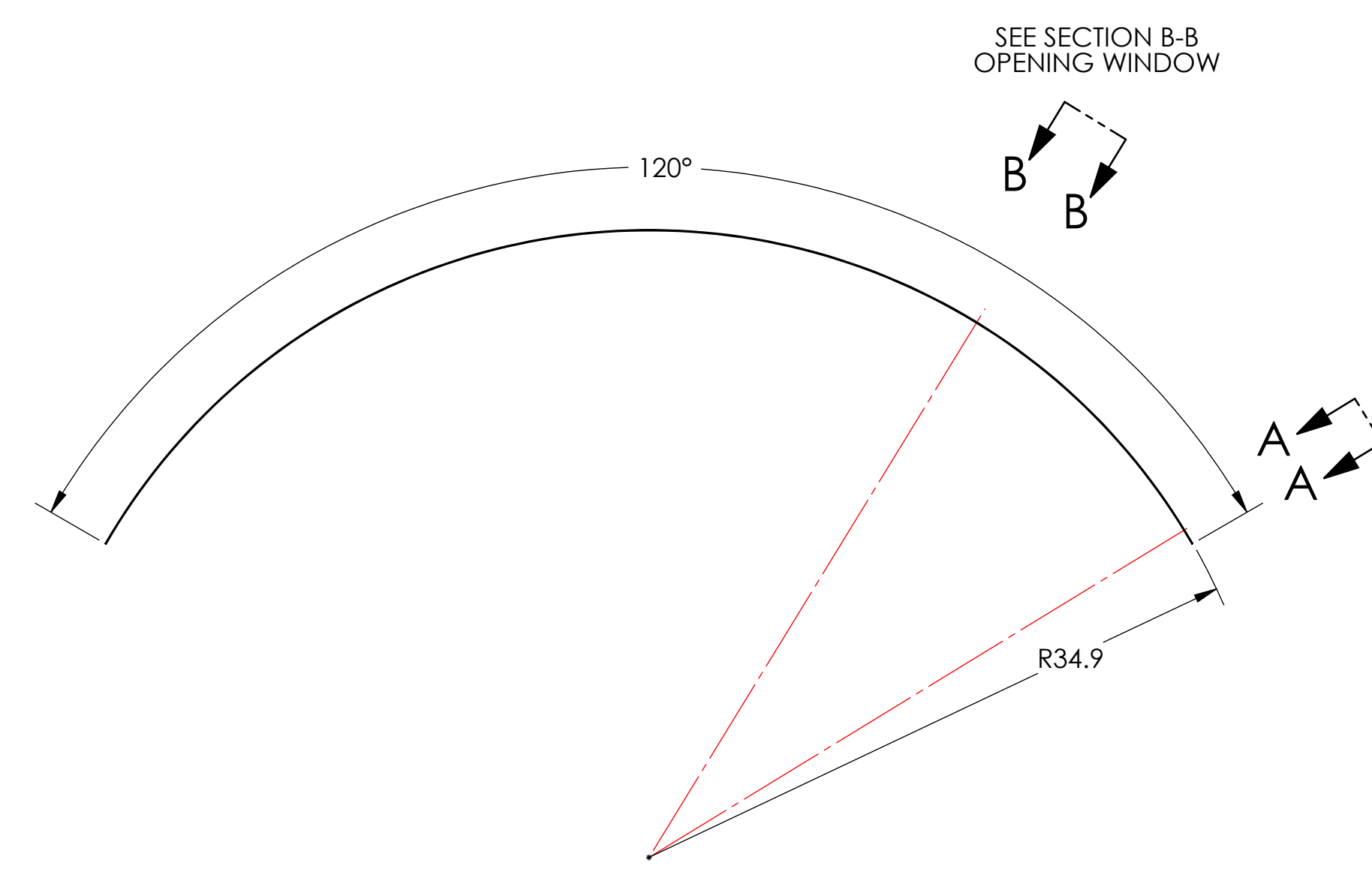
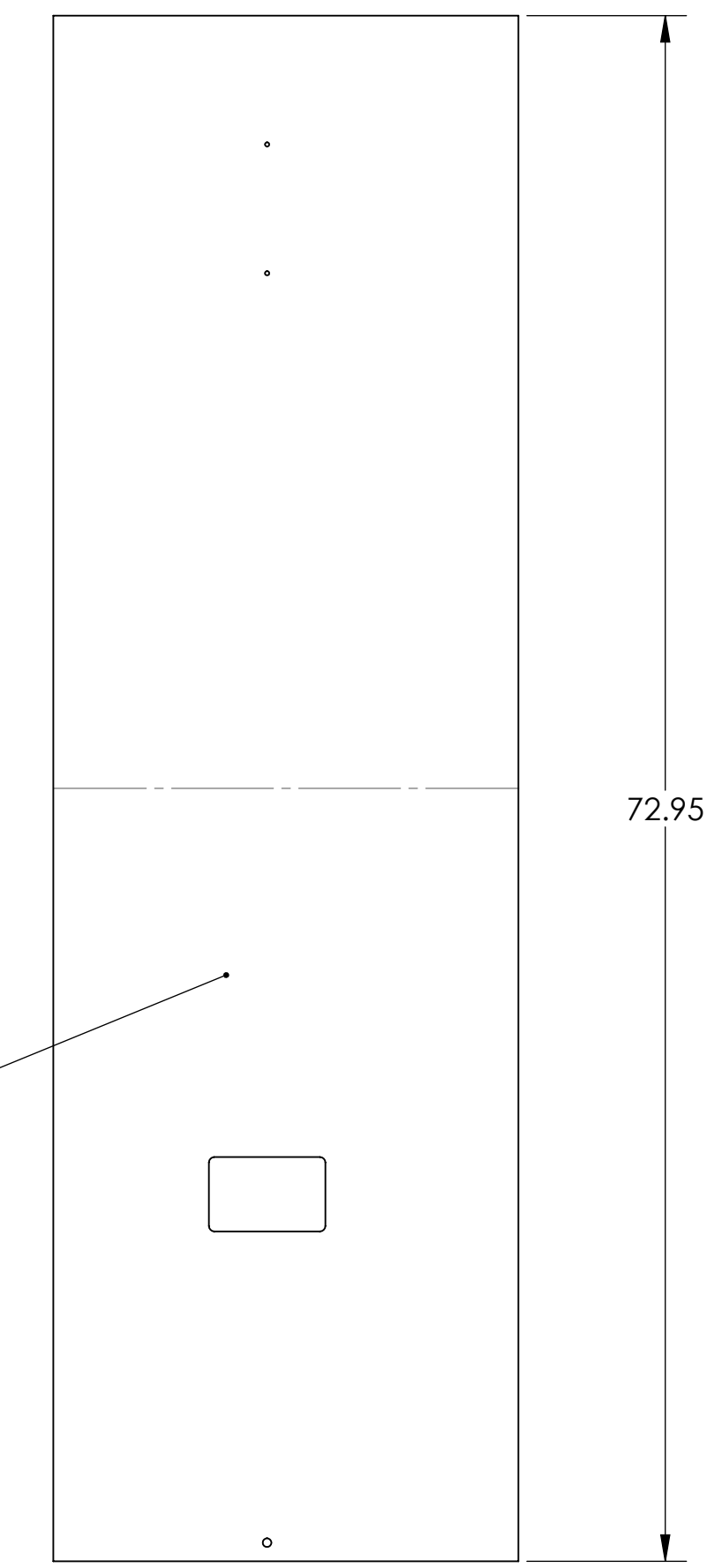
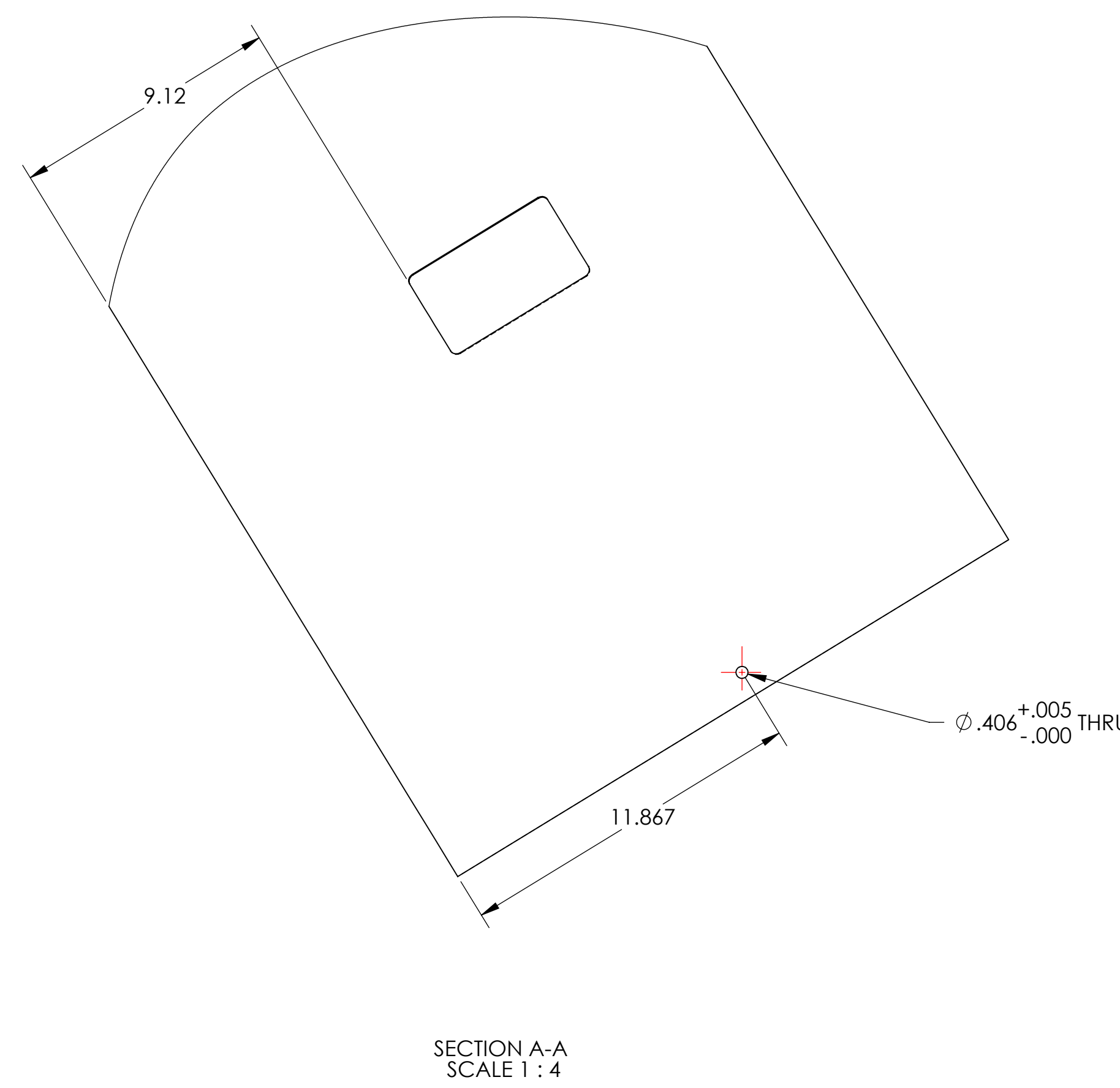
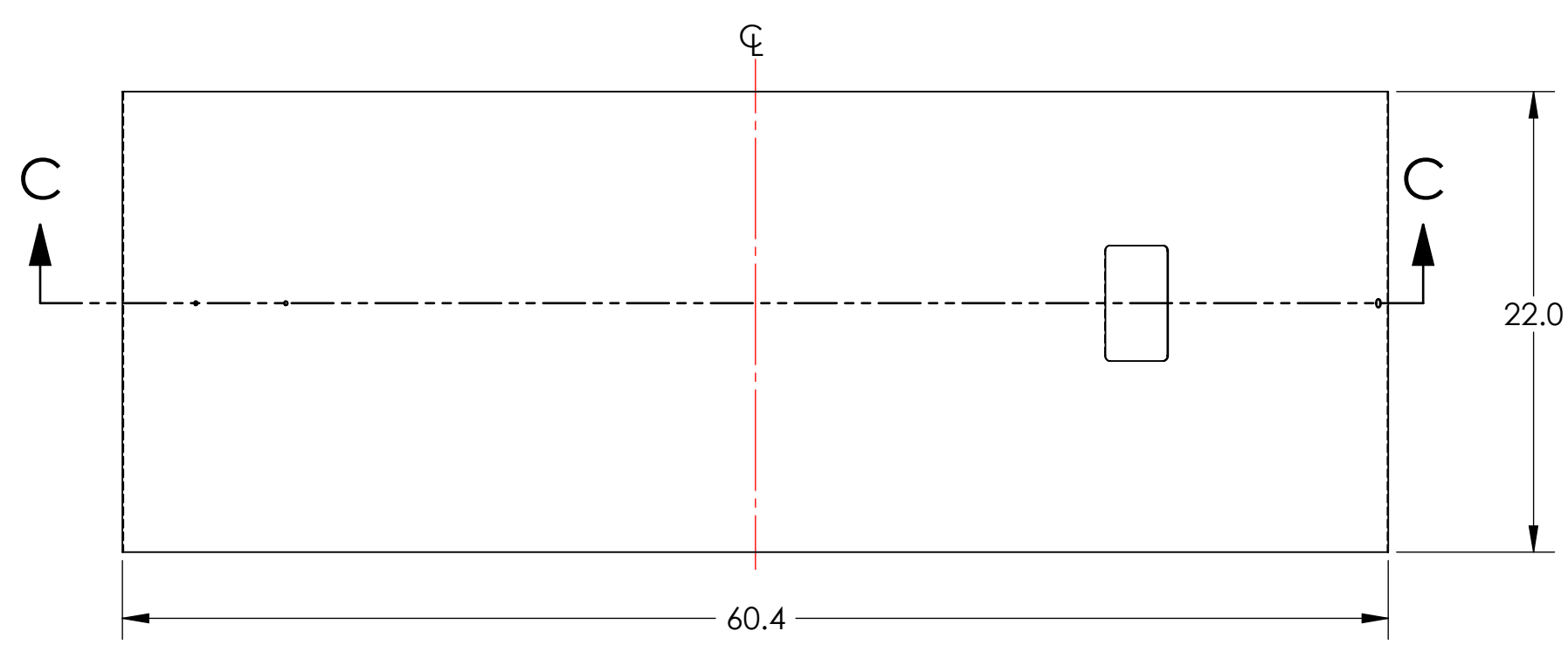
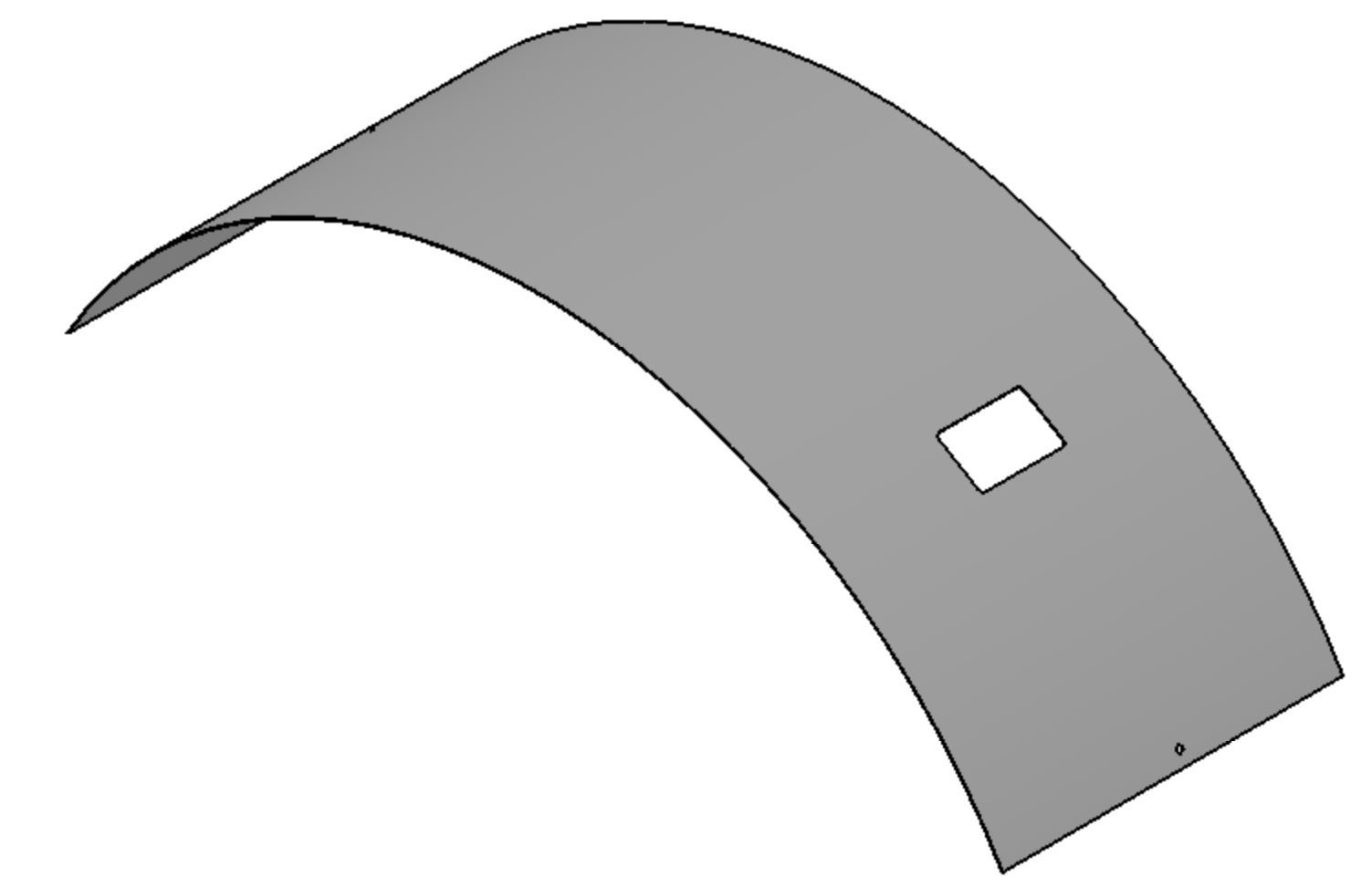
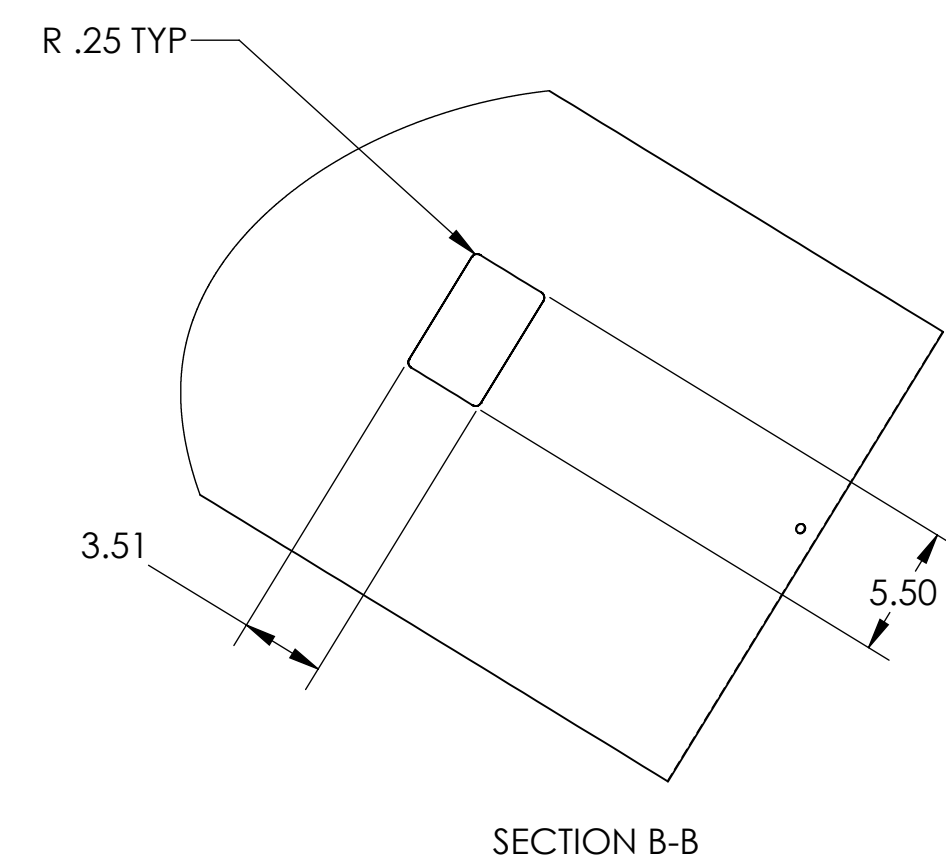
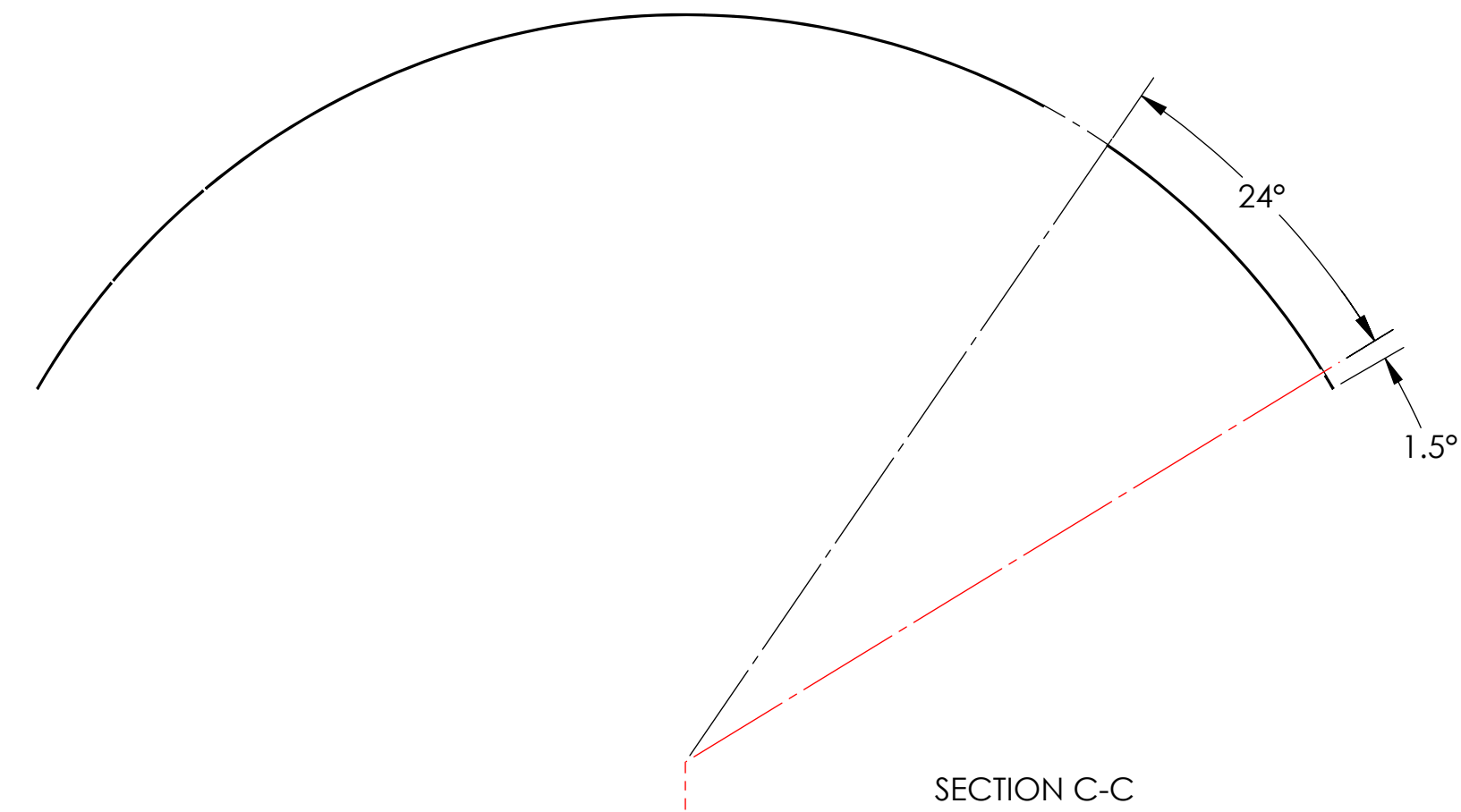
DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO		RADIAL SEGMENT, RIGHT	
ANGULAR ± 1.0°		MATERIAL 18GA A424 TYPE I STEEL		SYSTEM ADVANCED LIGO		DESIGNER H. KELMAN 17 MAR 2010	
		FINISH ⑥		SUB-SYSTEM AOS		DRAFTER TQ. NGUYEN 16 AUG 2010	
				NEXT ASSY D0902654		CHECKER M. SMITH	
						APPROVAL D. COYNE	
						SCALE: 1:8 PROJECTION:	
						SIZE DWG. NO. D1000559	
						REV. v1	
						SHEET 1 OF 1	

D:\000559_d\lco_MonField_Cryo_Baffle_RADIAL_SEGMENT_RIGHT_PART_IDM_REV.X:081_DRAWING_IDM_REV.X:028

NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

⑥ MATERIAL AS RECEIVED MACHINE FINISH

REV.	DATE	DCN #	DRAWING TREE #
V1	07 SEP 2010	E1000360	E1000090
-	-	-	-
-	-	-	-



SEE SECTION B-B OPENING WINDOW

THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902656 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO		RADIAL SEGMENT, LEFT	
ANGULAR ± 1.0°		MATERIAL 18GA A424 TYPE I STEEL		SUB-SYSTEM ADVANCED LIGO		DESIGNER H. KELMAN 17 MAR 2010	
		FINISH ⑥		NEXT ASSY D0902656		DRAFTER TQ. NGUYEN 16 AUG 2010	
						CHECKER M. SMITH	
						APPROVAL D. COYNE	
						SCALE: 1:8 PROJECTION:	
						SIZE DWG. NO. D1000558 REV. v1	
						SHEET 1 OF 1	

D1000558_dLIGO_Monolith_Cryo_Baffle_RadialSegment_Left_PART.PDM.REV.X.081.DRAWING.PDM.REV.X.009

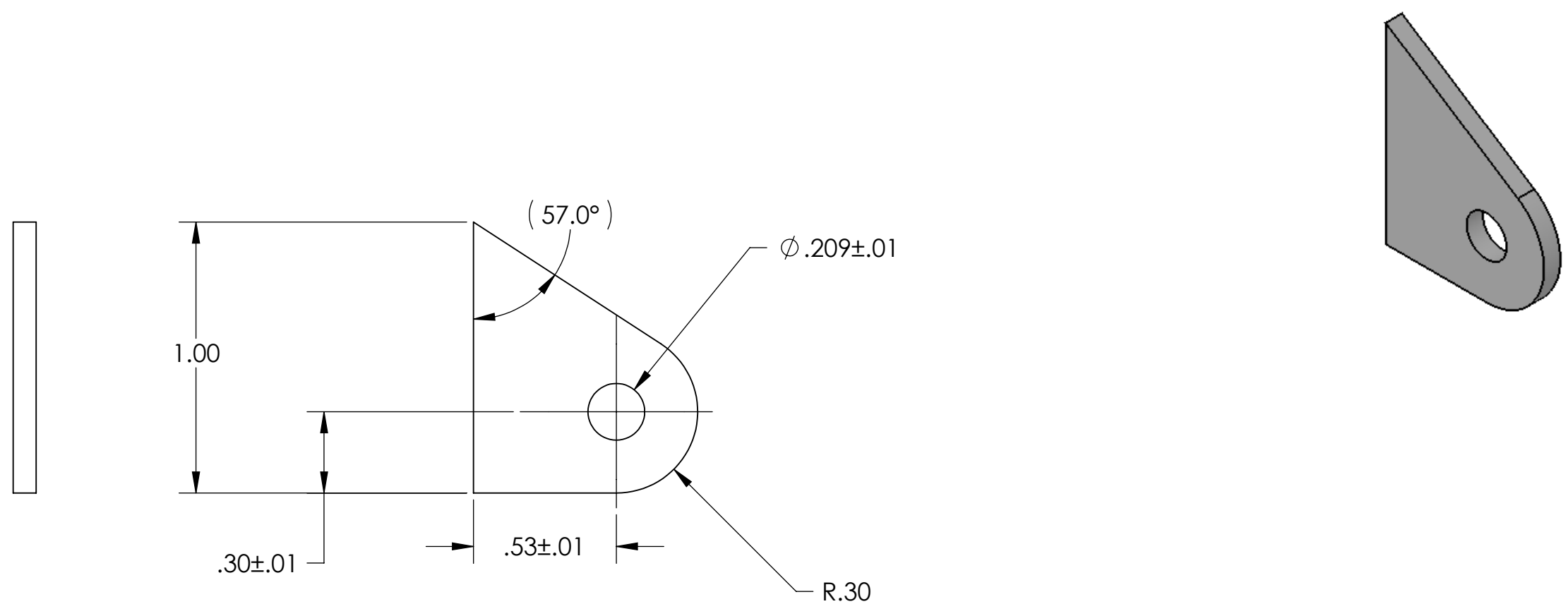
NOTES CONTINUED:

⑤ BAG AND TAG WITH DRAWING PART NUMBER AND REVISION FOLLOWED BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. EXAMPLE: DXXXXXX-VY, S/N 001.

⑥ AS RECEIVED MACHINED FINISH.

REV.	DATE	DCN #	DRAWING TREE #
V1	17 MAR 2010	E1000360	E1000090-v1
-	-	-	E1000091-v1
-	-	-	E1000367-v1

D1000536_dLIGO_Manifold_Cryo_Baffle_Bracket, PART PDM REV: X-022, DRAWING PDM REV: X-011



THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE NEXT ASSEMBLY FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDING.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN	1. INTERPRET DRAWING PER ASME Y14.5-1994.
TOLERANCES:	2. REMOVE ALL SHARP EDGES, R.02 MIN.
.XX ± .06	3. DO NOT SCALE FROM DRAWING.
.XXX ± .010	4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.
ANGULAR ±1.0°	
MATERIAL	14GA A424 TYPE I STEEL
FINISH	⑥

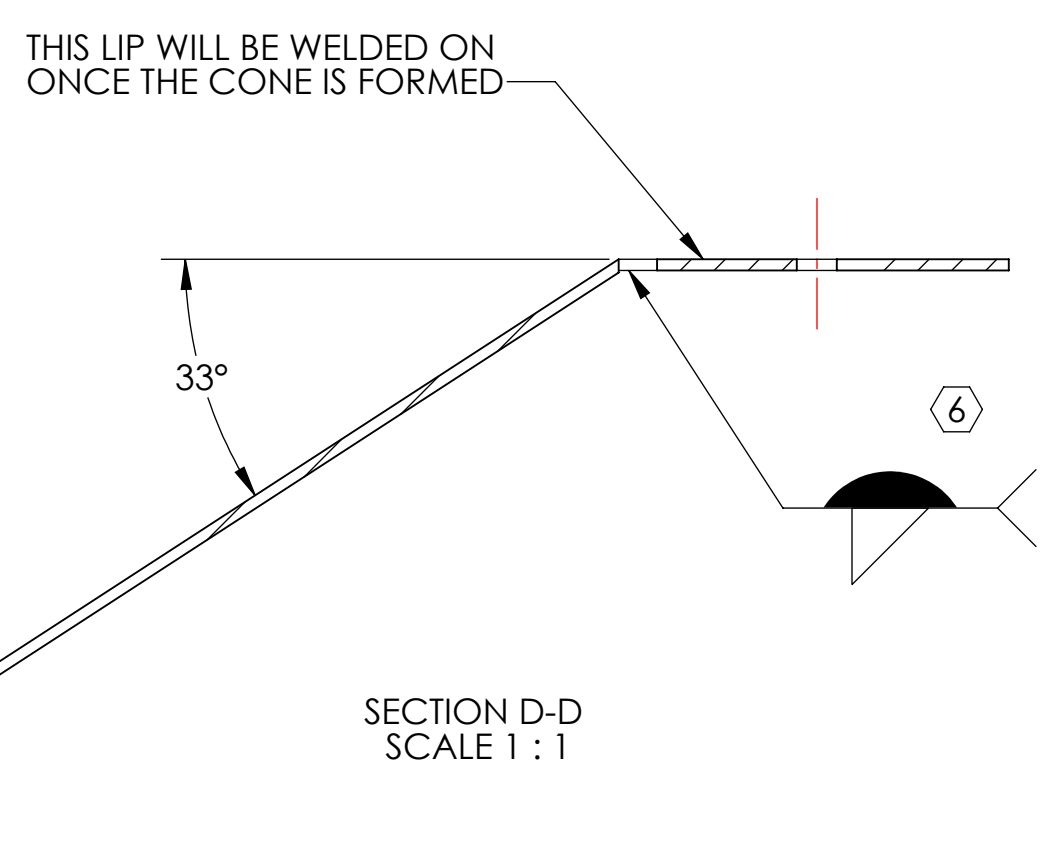
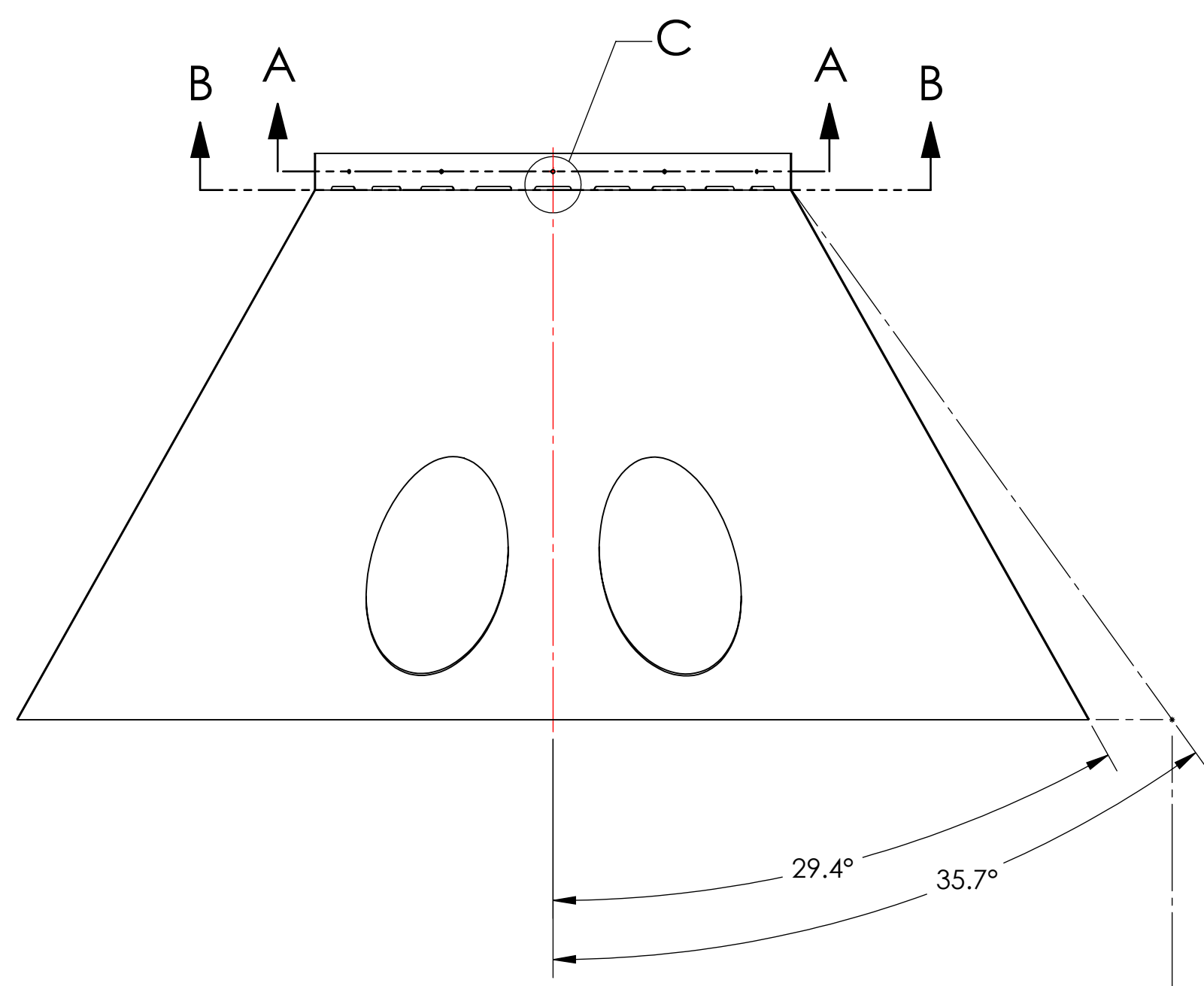
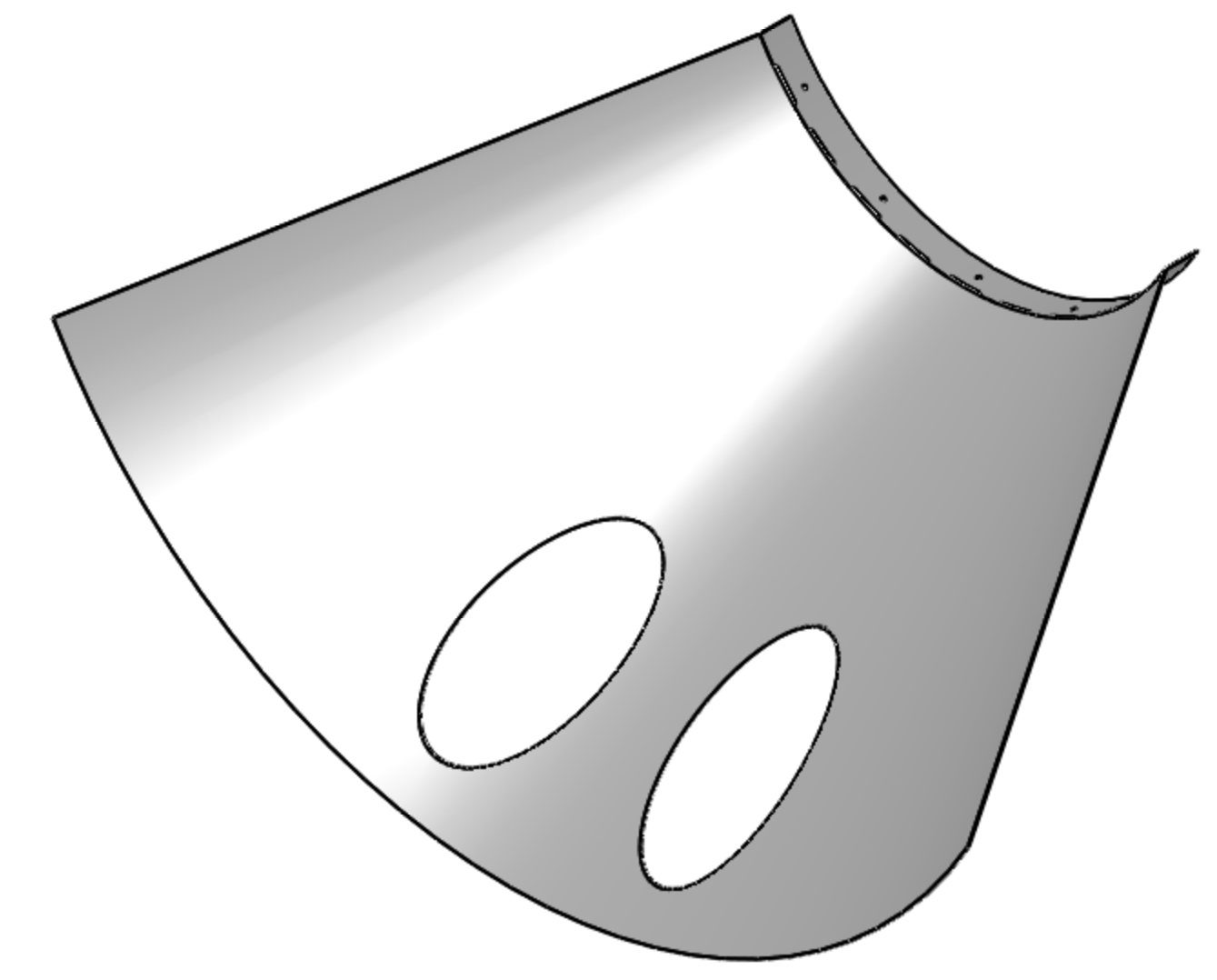
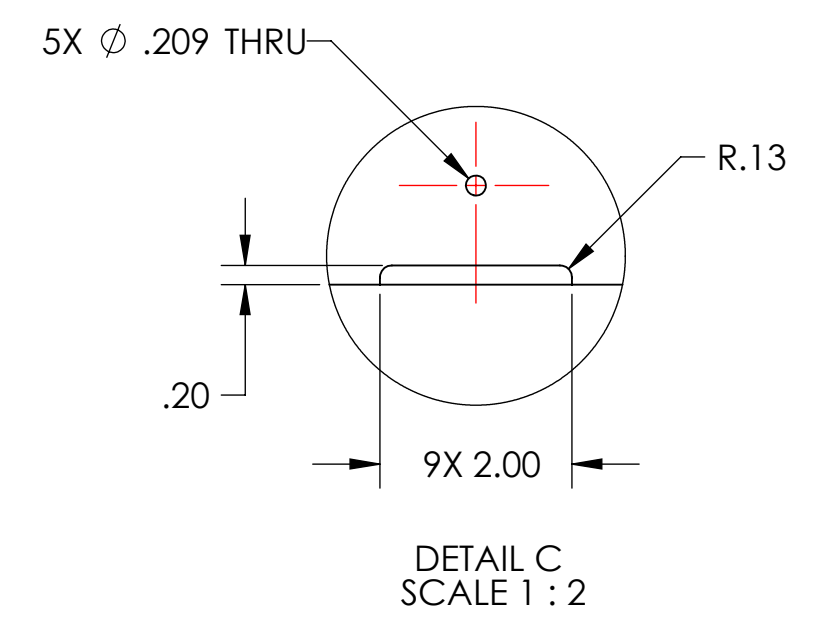
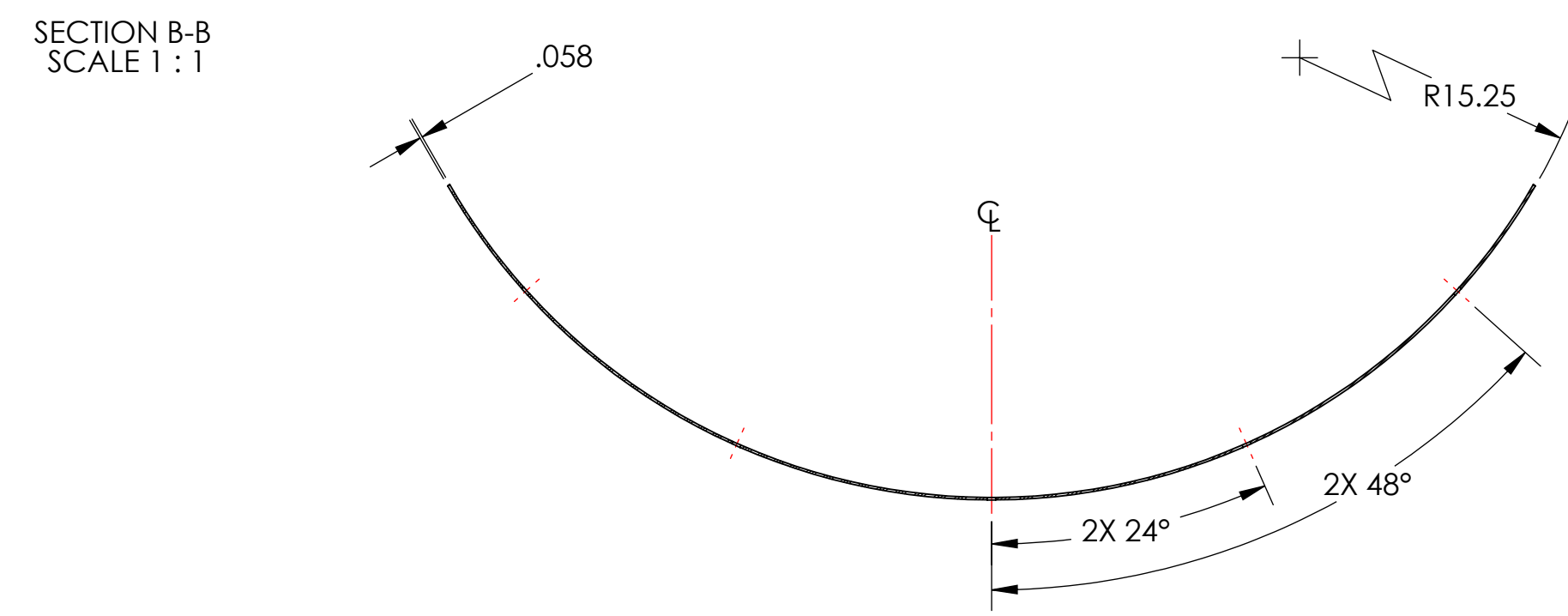
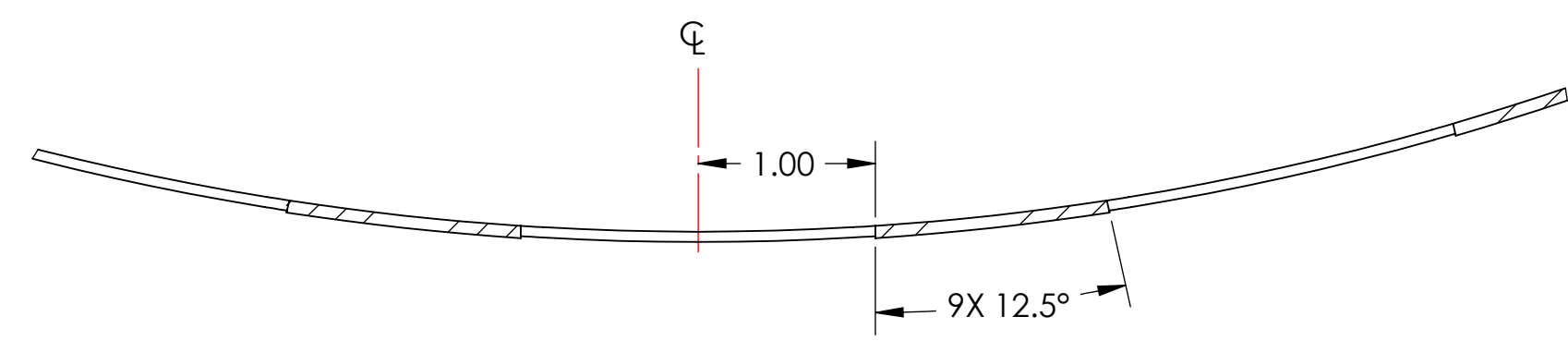
CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME		Baffle Brace Bracket	
SYSTEM	ADVANCED LIGO	SUB-SYSTEM	AOS	DESIGNER	H. Keltman
NEXT ASSY	D0902654, D0902655, D1001348	CHECKER		DATE	17 MAR 2010
		APPROVAL		SIZE	DWG. NO.
				B	D1000536
				REV.	v1
				SCALE: 2:1	PROJECTION:
					SHEET 1 OF 1

NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

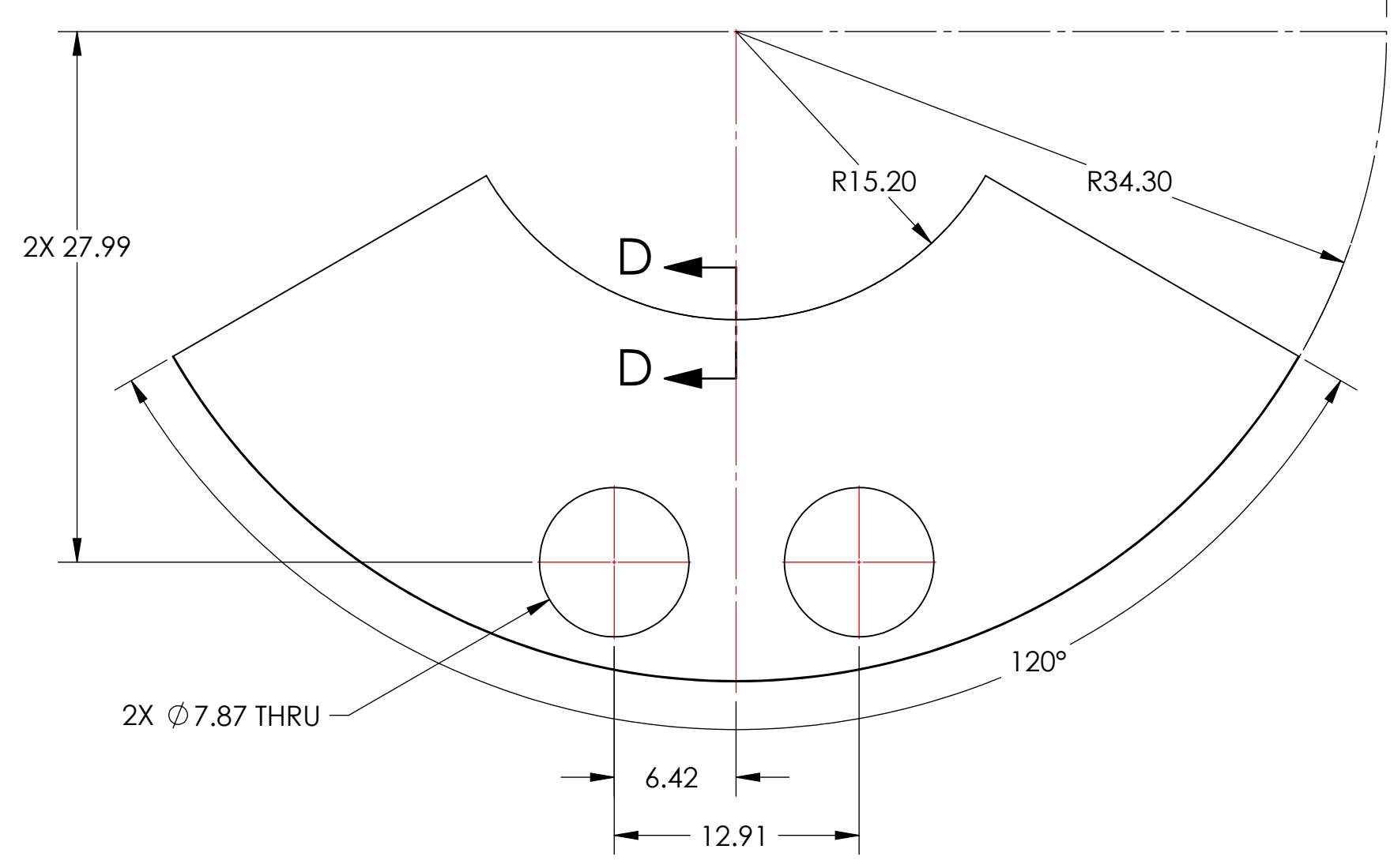
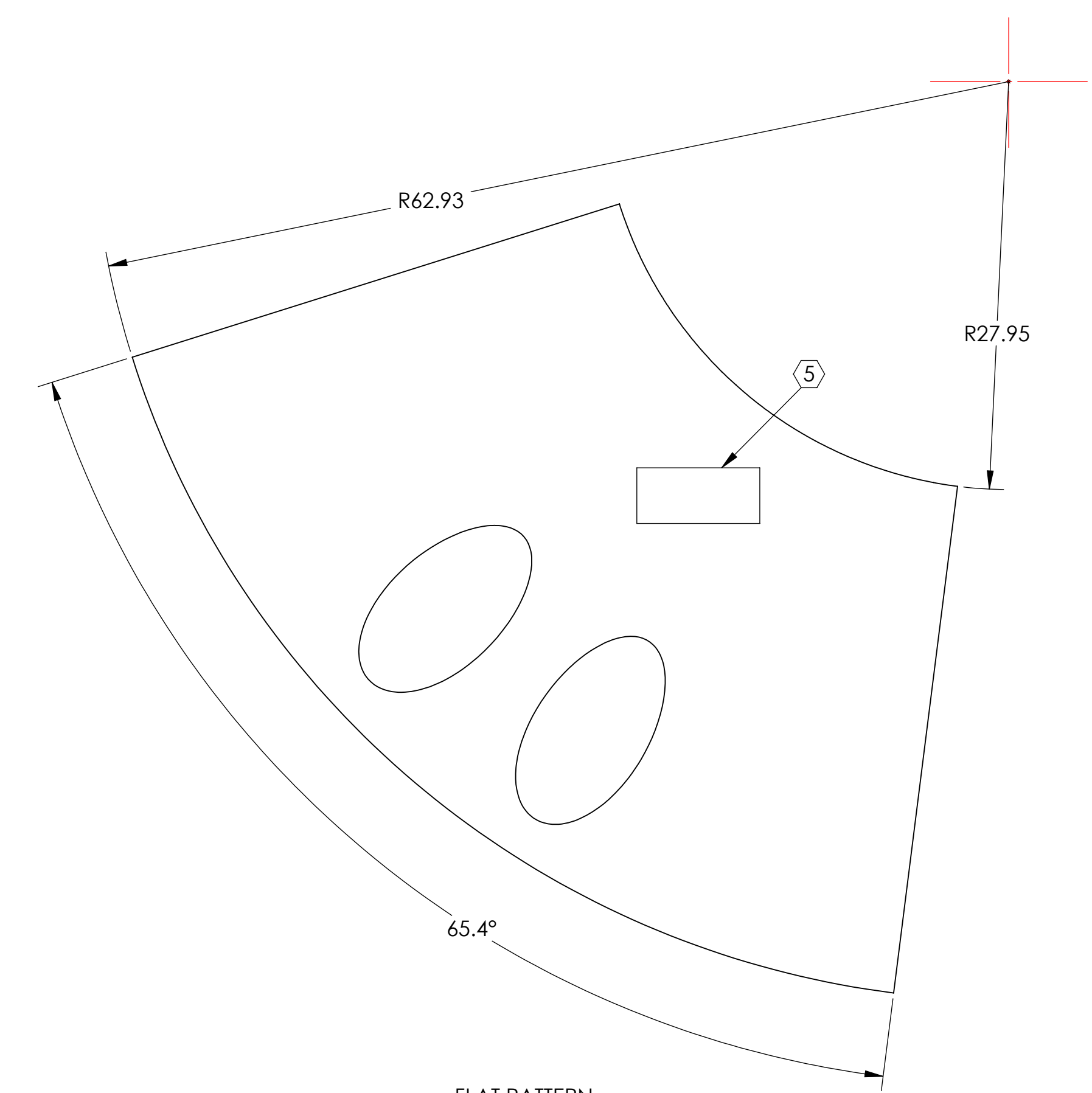
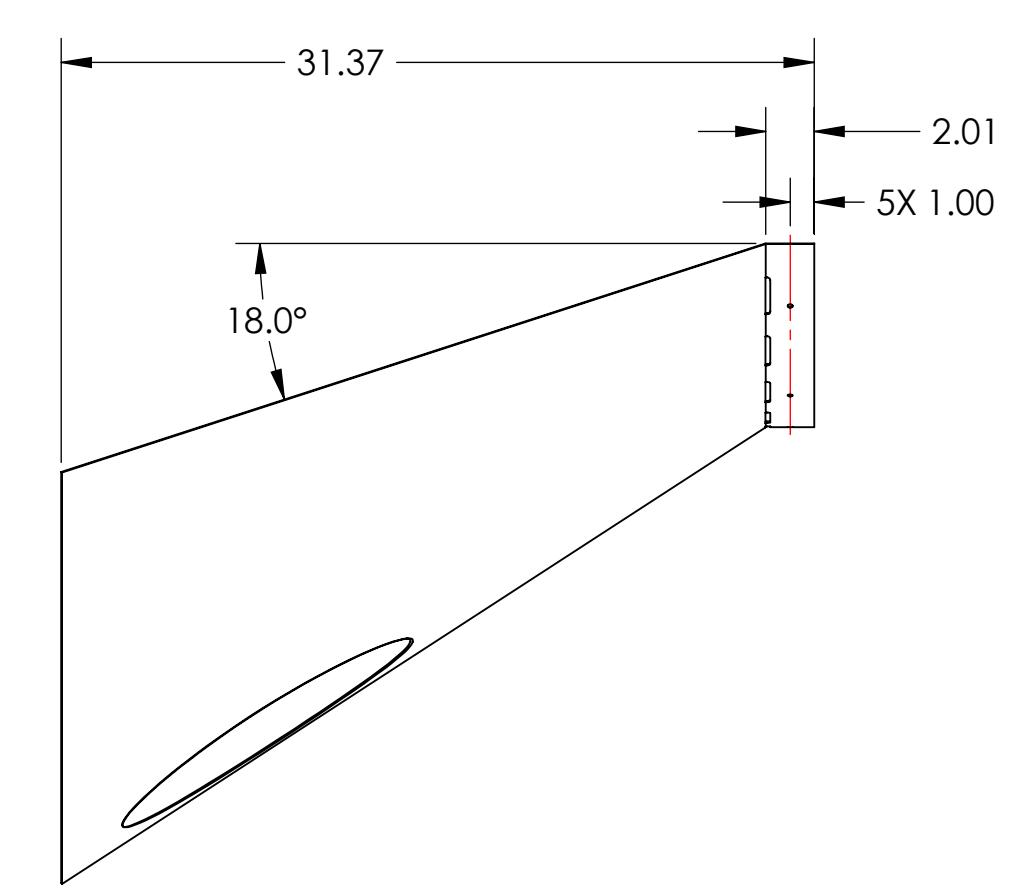
⑥ CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.

⑦ MATERIAL AS RECEIVED MACHINE FINISH

REV.	DATE	DCN #	DRAWING TREE #
V1	07 SEP 2010	E1000360	E1000085
-	-	-	-
-	-	-	-



10 PLS



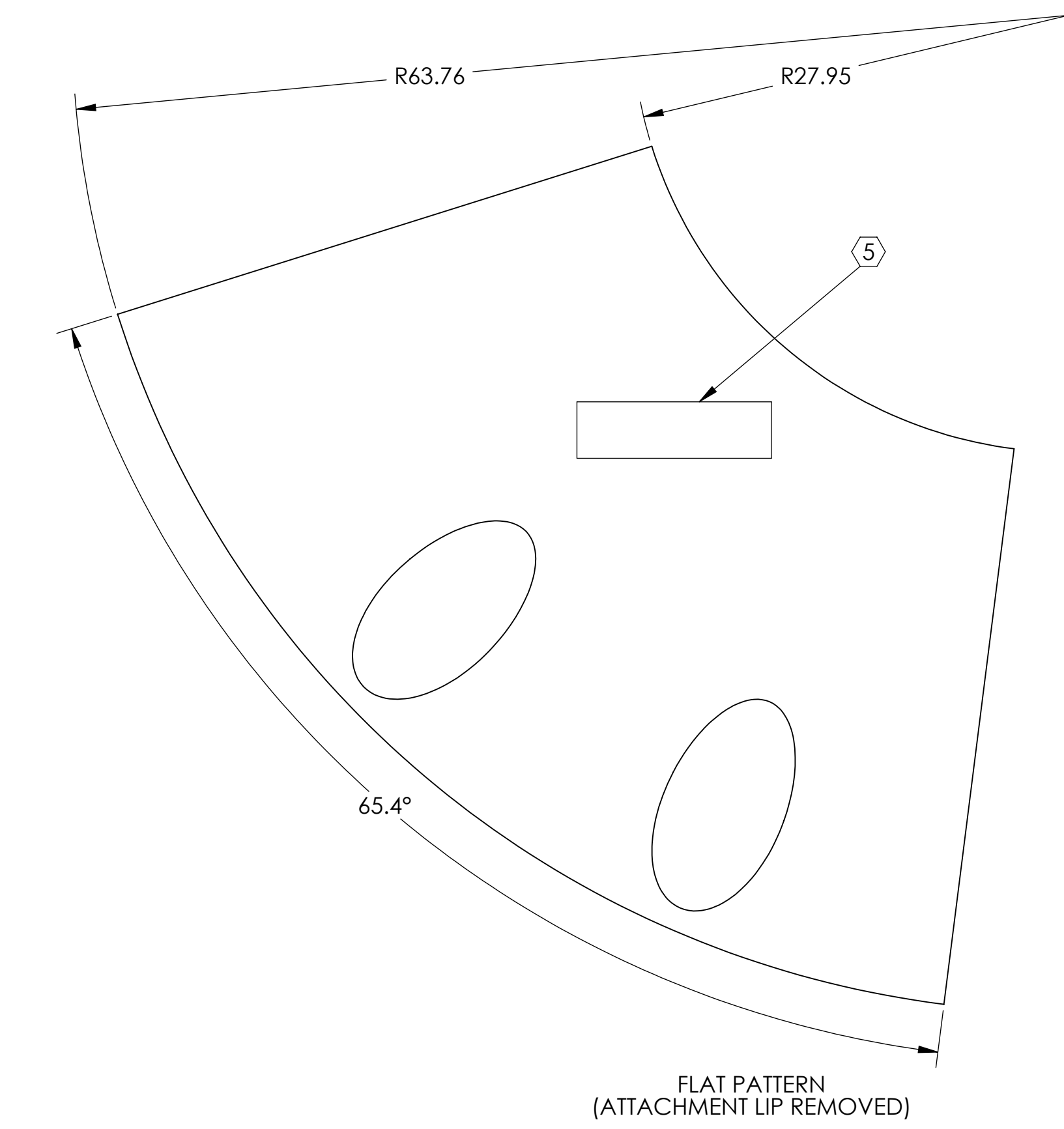
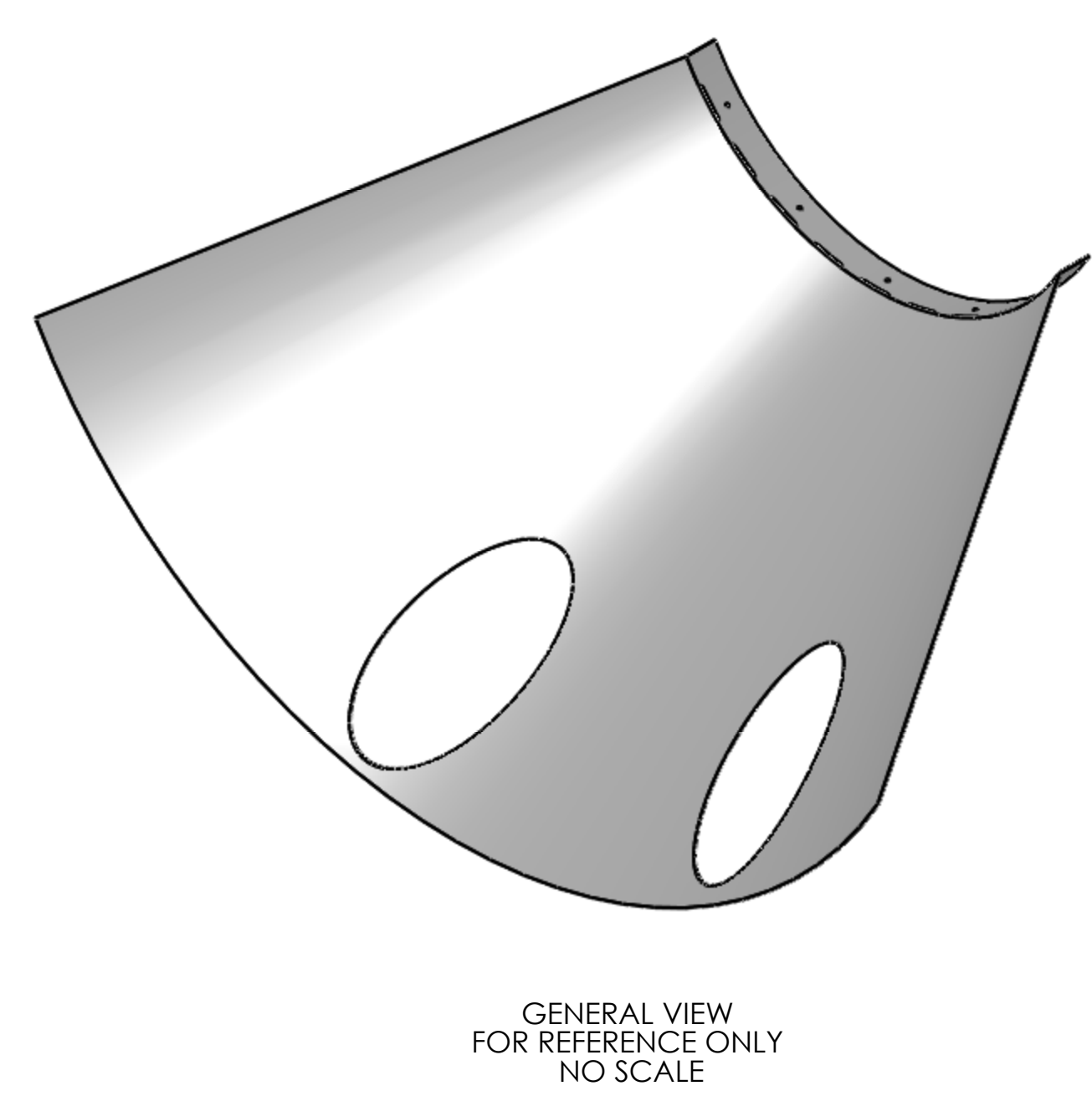
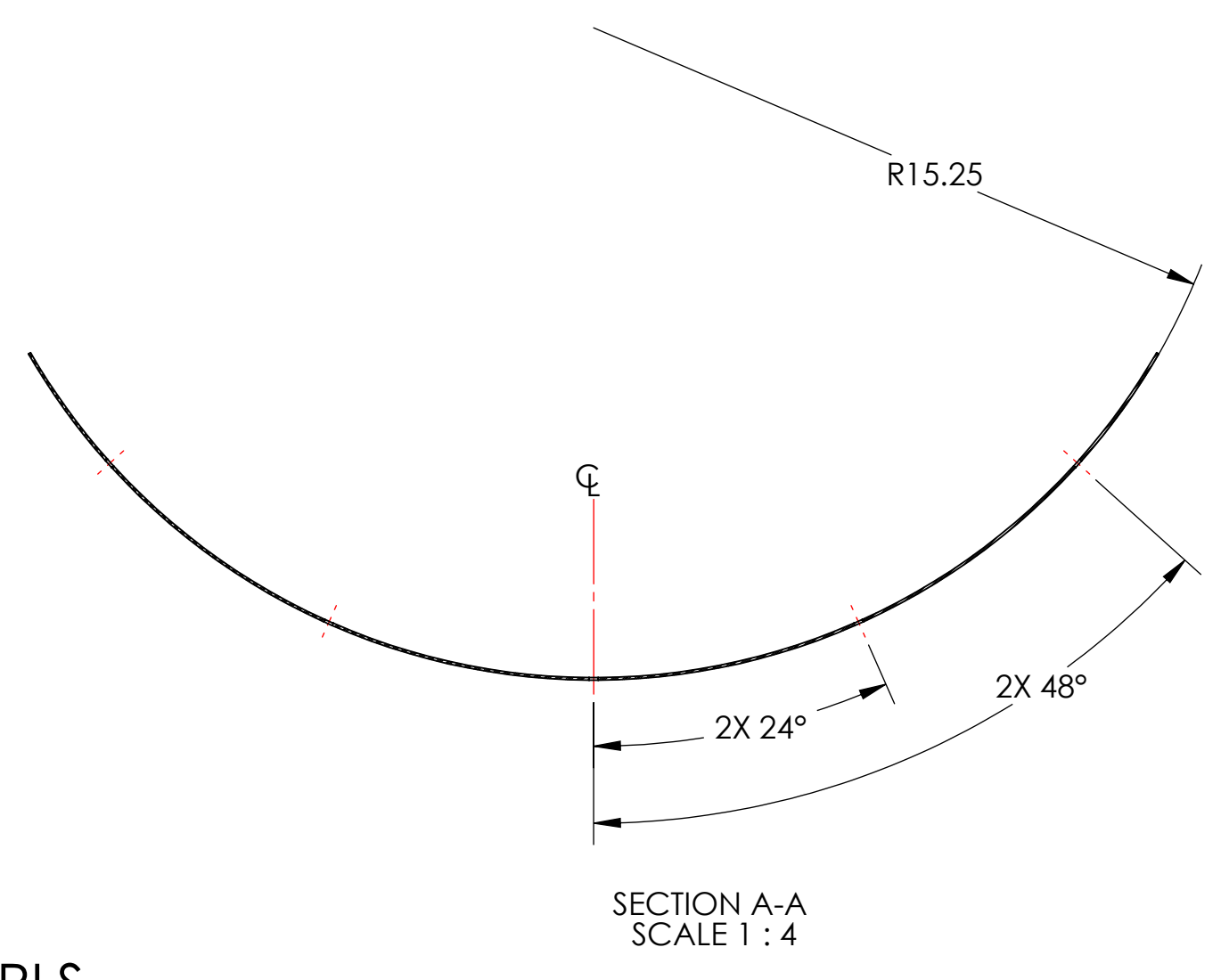
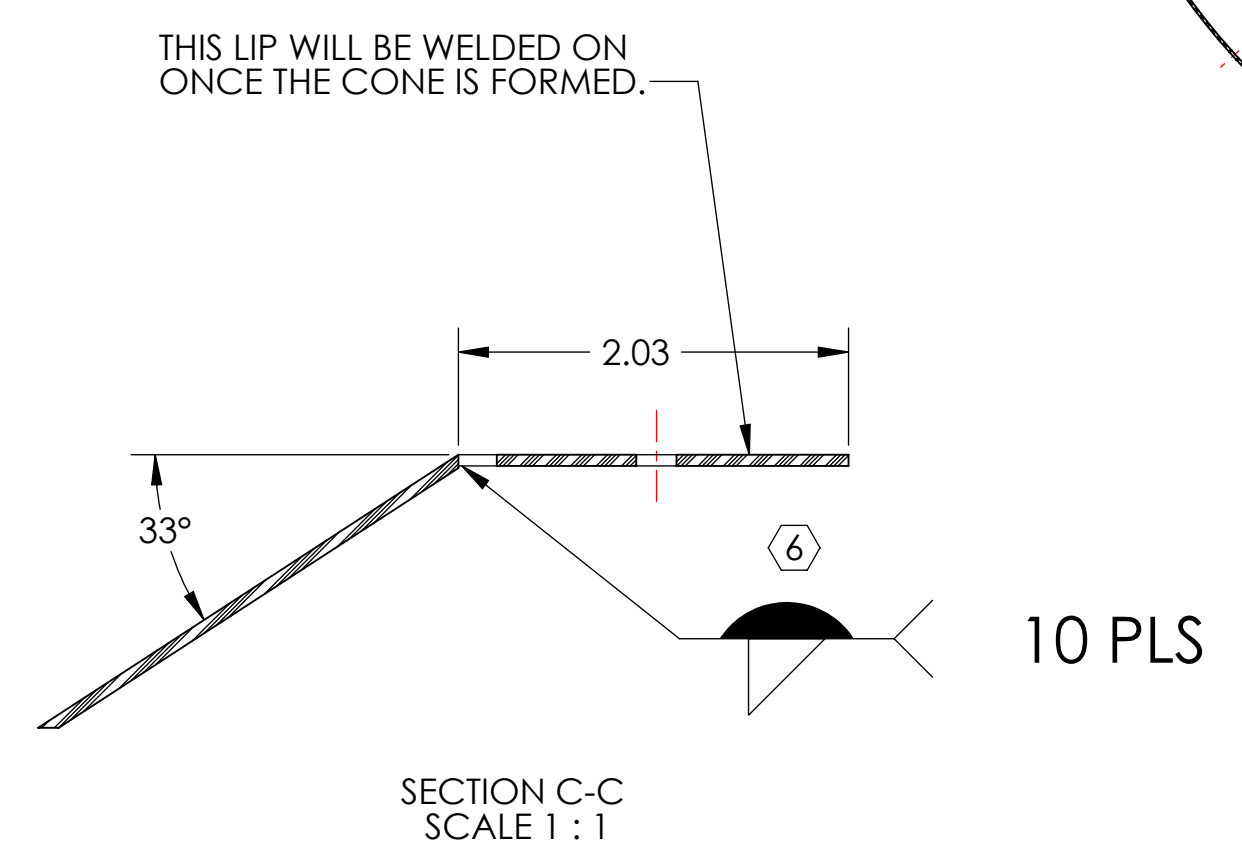
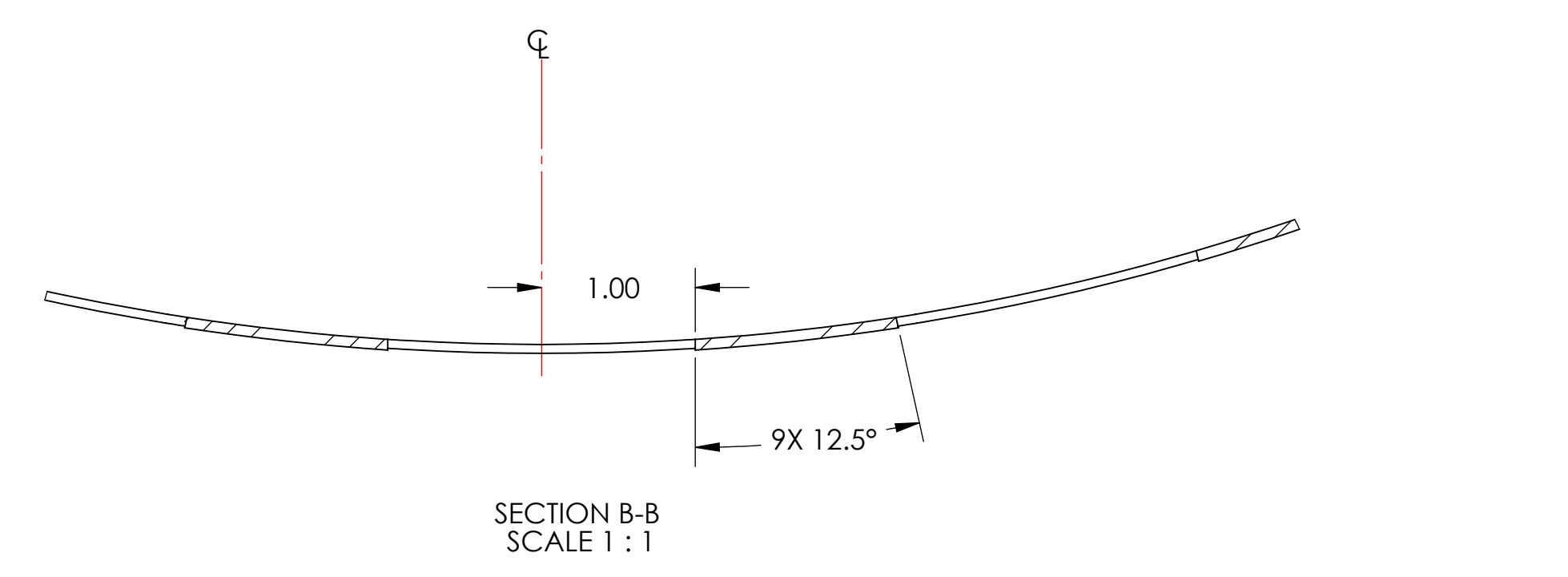
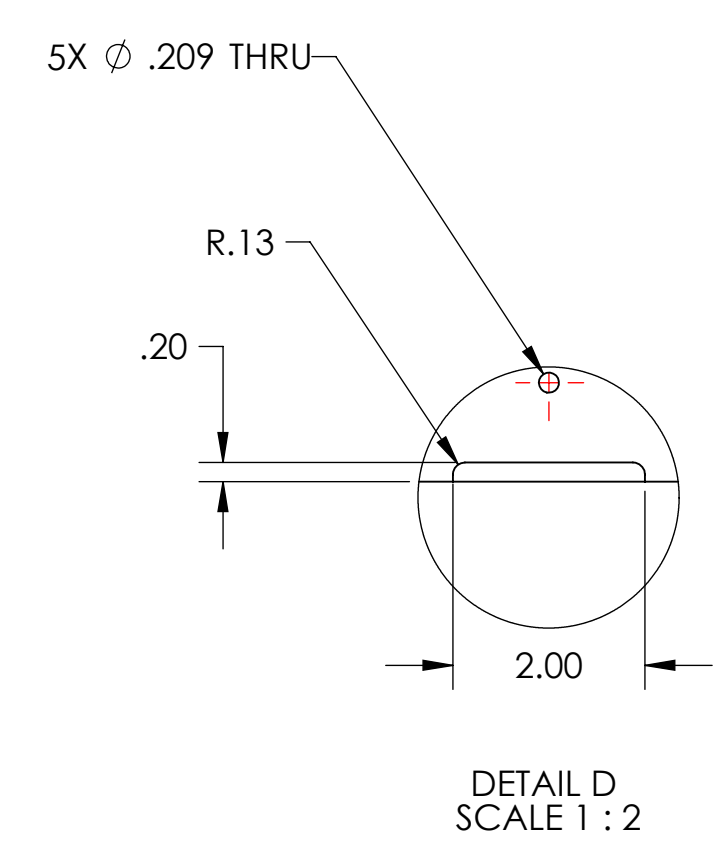
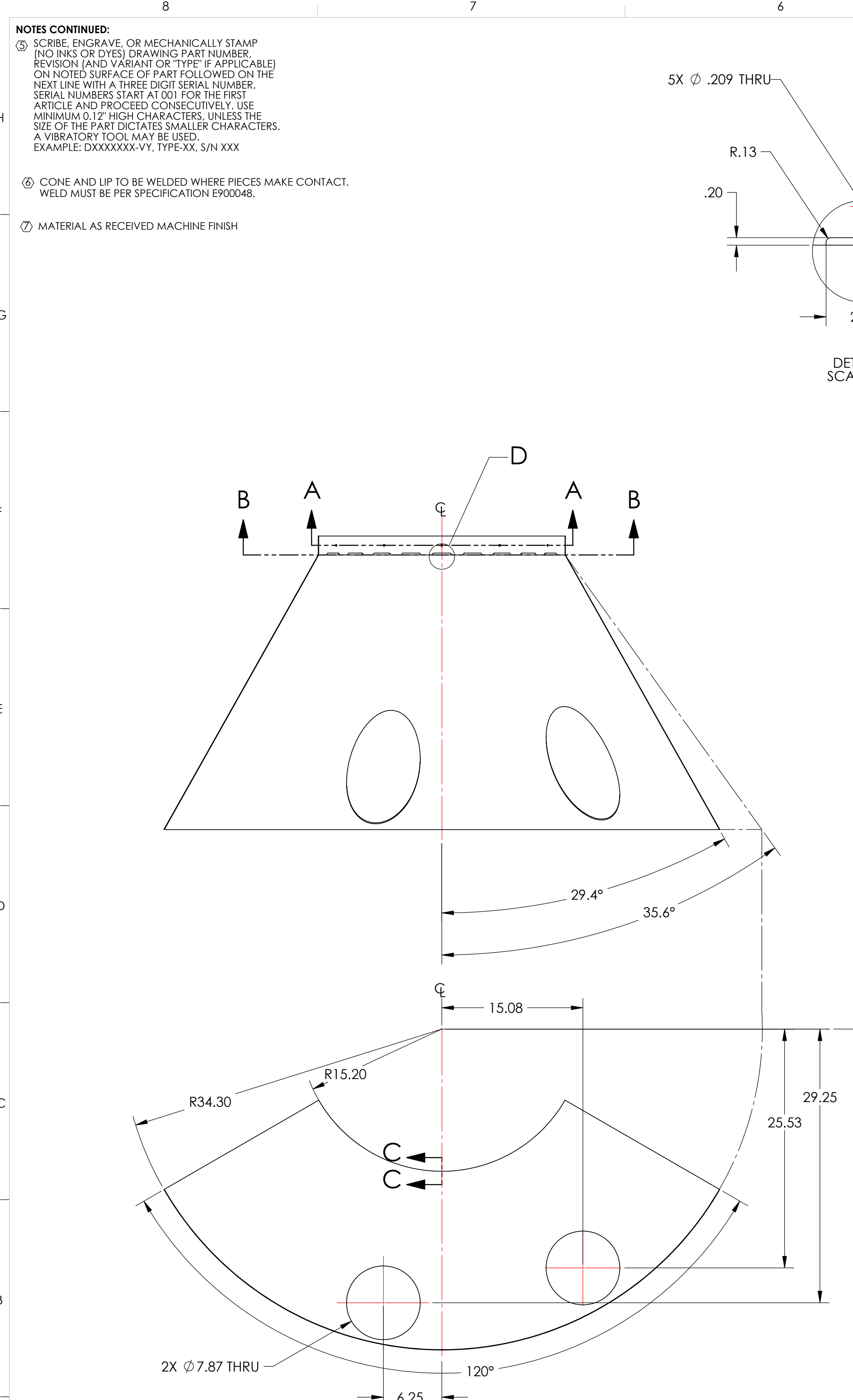
THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902655 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
TOLERANCES: .XX ± .06 .XXX ± .010		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
MATERIAL	FINISH	ANGULAR ± 0.5°	
18GA A424 TYPE I STEEL	⑦		

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	PART NAME	MANIFOLD-CRYO BAFFLE INNER SEGMENT, ITMX H1-H2, BOTTOM	
SYSTEM	DESIGNER	DATE	SIZE DWG. NO.
ADVANCED LIGO	H. KELMAN	03-15-10	D
SUB-SYSTEM	DRAFTER	17 AUG 2010	D0902623
AOS	CHECKER	M. SMITH	
NEXT ASSY	APPROVAL	D. COYNE	
D0902655			

SCALE: 1:8	PROJECTION:	SHEET 1 OF 1
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D0902623.dwg; Manifold_Cryo_Baffle_Inner_Segment; ITMX H1-H2_Bottom; PART PDM REV: X01.5; DRAWING PDM REV: X007



THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902656 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

⑥ CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT. WELD MUST BE PER SPECIFICATION E900048.

⑦ MATERIAL AS RECEIVED MACHINE FINISH

REV.	DATE	DCN #	DRAWING TREE #
V1	07 SEP 2010	E1000360	E1000090
-	-	-	-
-	-	-	-

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .XX ± .06 .XXX ± .010	
ANGULAR ± 0.5°	
MATERIAL	FINISH
18GA A424 TYPE I STEEL	⑦

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	SYSTEM	SUB-SYSTEM
ADVANCED LIGO		AOS
NEXT ASSY	D0902656	

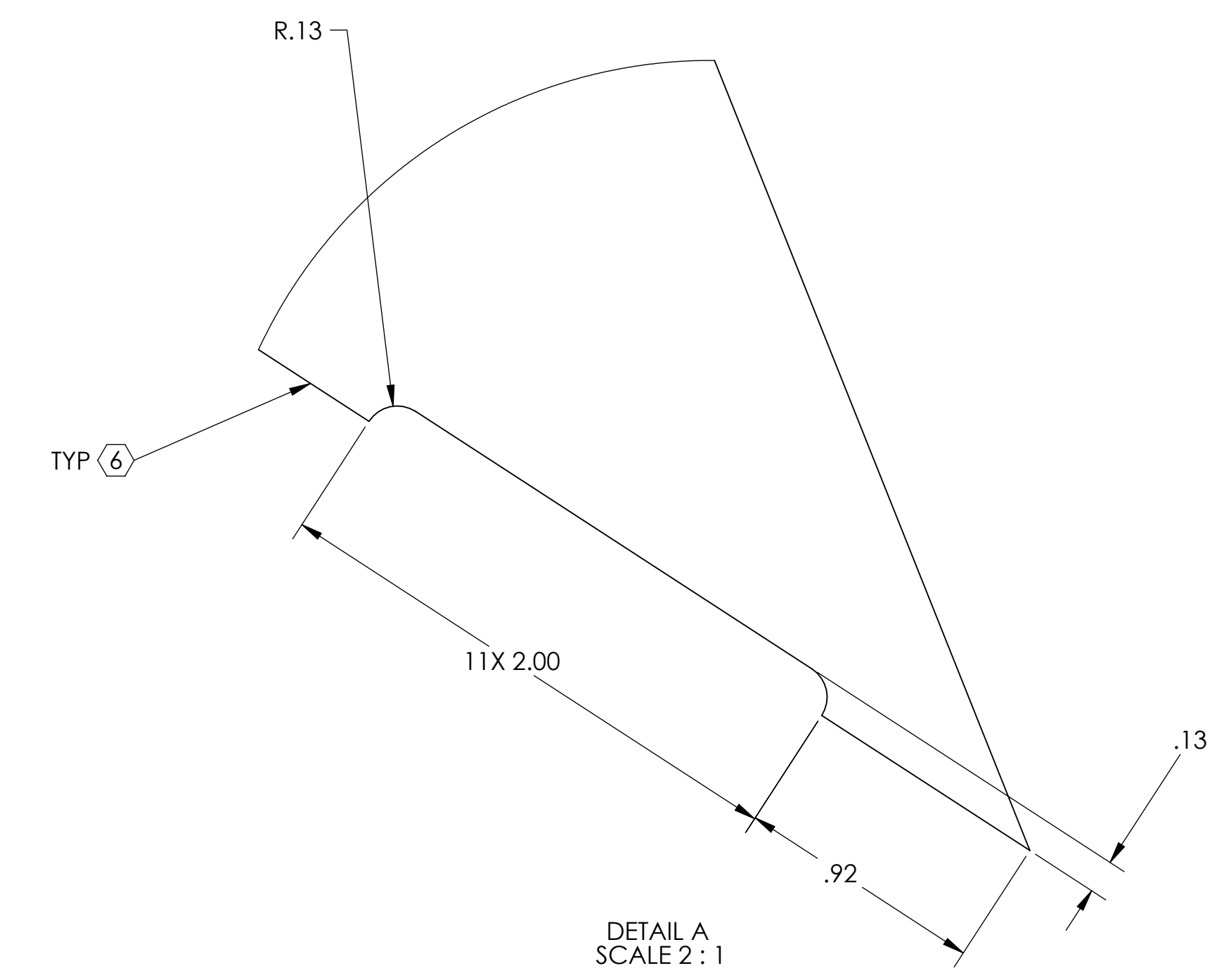
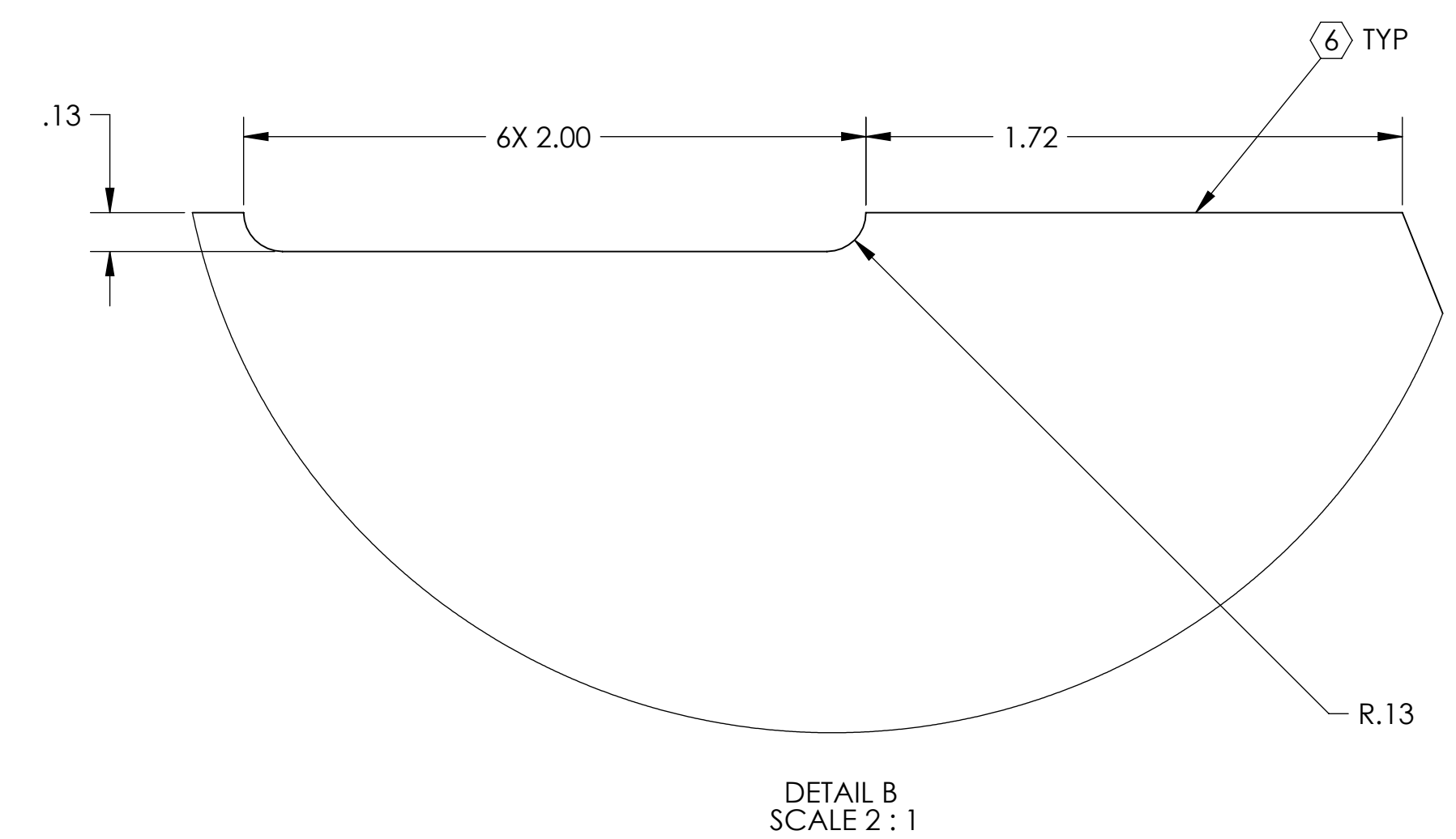
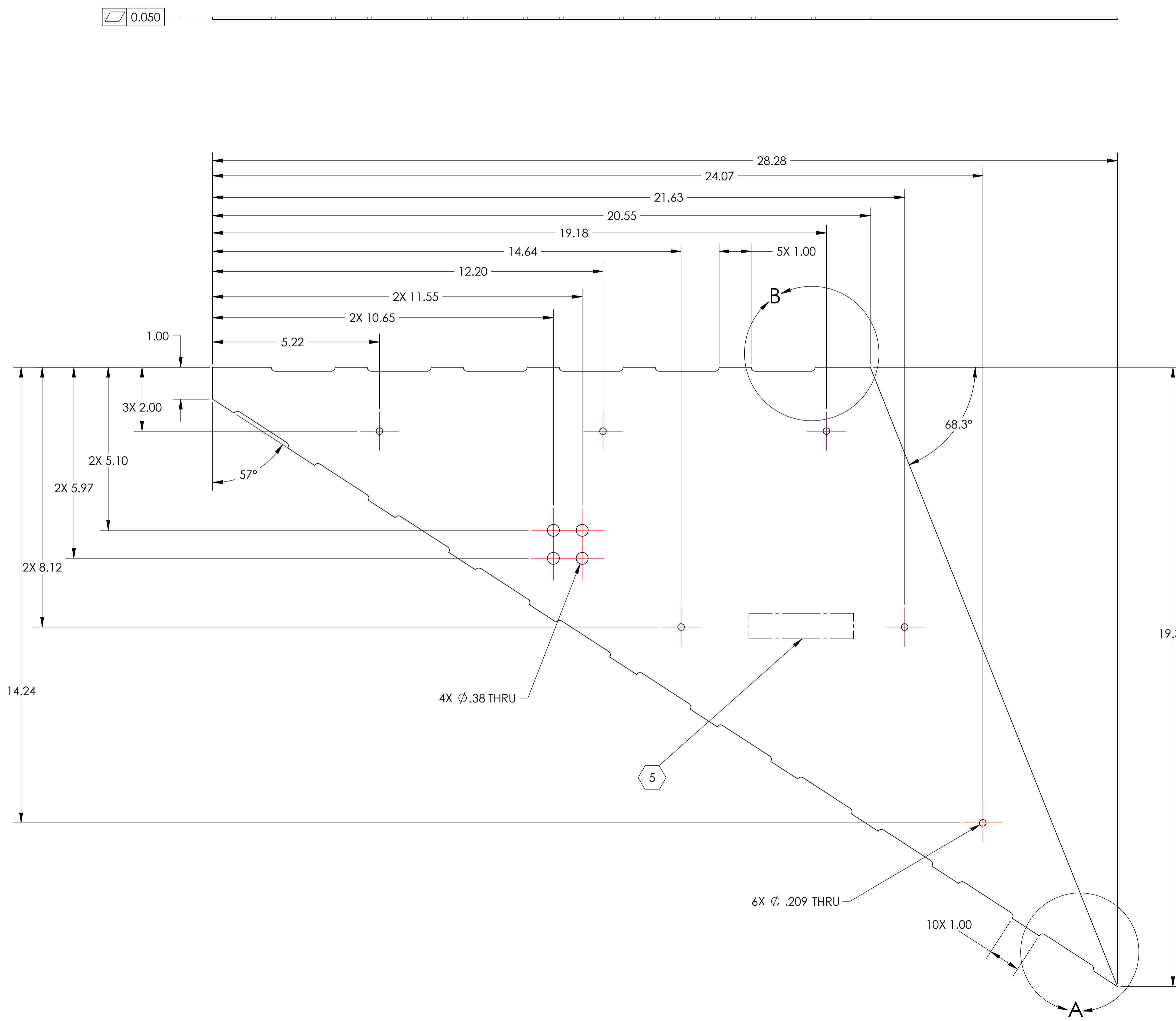
PART NAME		MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ITMX H1-H2, LEFT	
DESIGNER	H. KELMAN	12 MAY 2010	SIZE DWG. NO.
DRAFTER	TQ. NGUYEN	17 AUG 2010	D
CHECKER	M. SMITH		D0902622
APPROVAL	D. COYNE		SCALE: 1:8 PROJECTION:
REV.	V1		SHEET 1 OF 1

NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER AND REVISION ON NOTED SURFACE FOLLOWED ON THE NEXT LINE BY A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE .07" HIGH CHARACTERS. EXAMPLE: DXXXXXX-VY, S/N 001. VIBRATORY TOOL MAY BE USED.

⑥ CASTELLATION ON MATERIAL EDGES ARE FOR WELD PURPOSES IN ASSEMBLIES (D0902654, D0902655, D0902656).

⑦ AS RECEIVED MACHINE FINISH.

REV.	DATE	DCN #	DRAWING TREE #
V1	17 MAR 2010	E1000360	E1000085-v1
-	-	-	E1000090-v1
-	-	-	E1000091-v1



THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE NEXT ASSEMBLY FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDING.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	
DIMENSIONS ARE IN INCHES	TOLERANCES: .XX ± .06 .XXX ± .010
ANGULAR ± 1.0°	
MATERIAL 14GA A424 TYPE I STEEL	FINISH ⑦ μinch

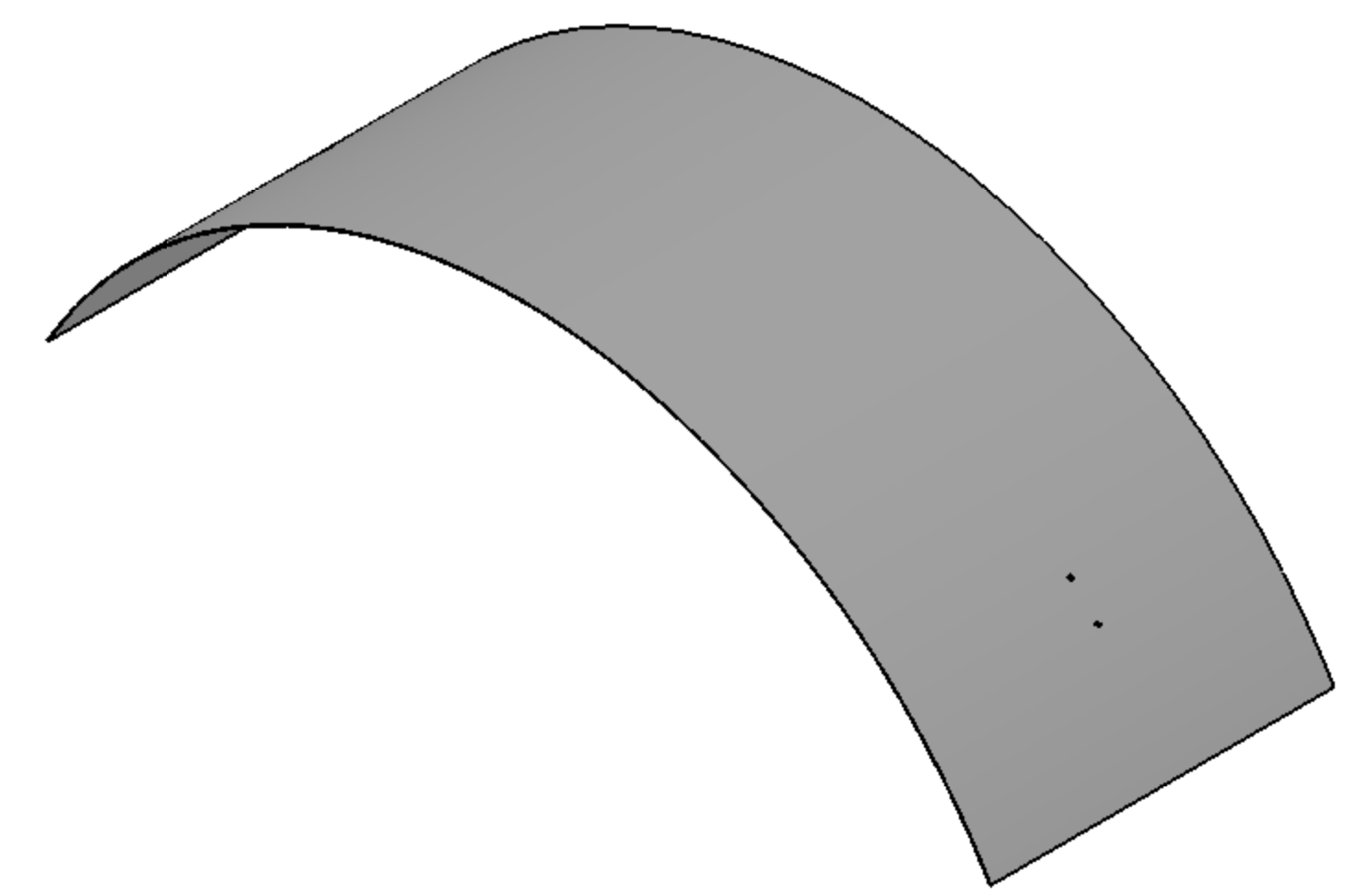
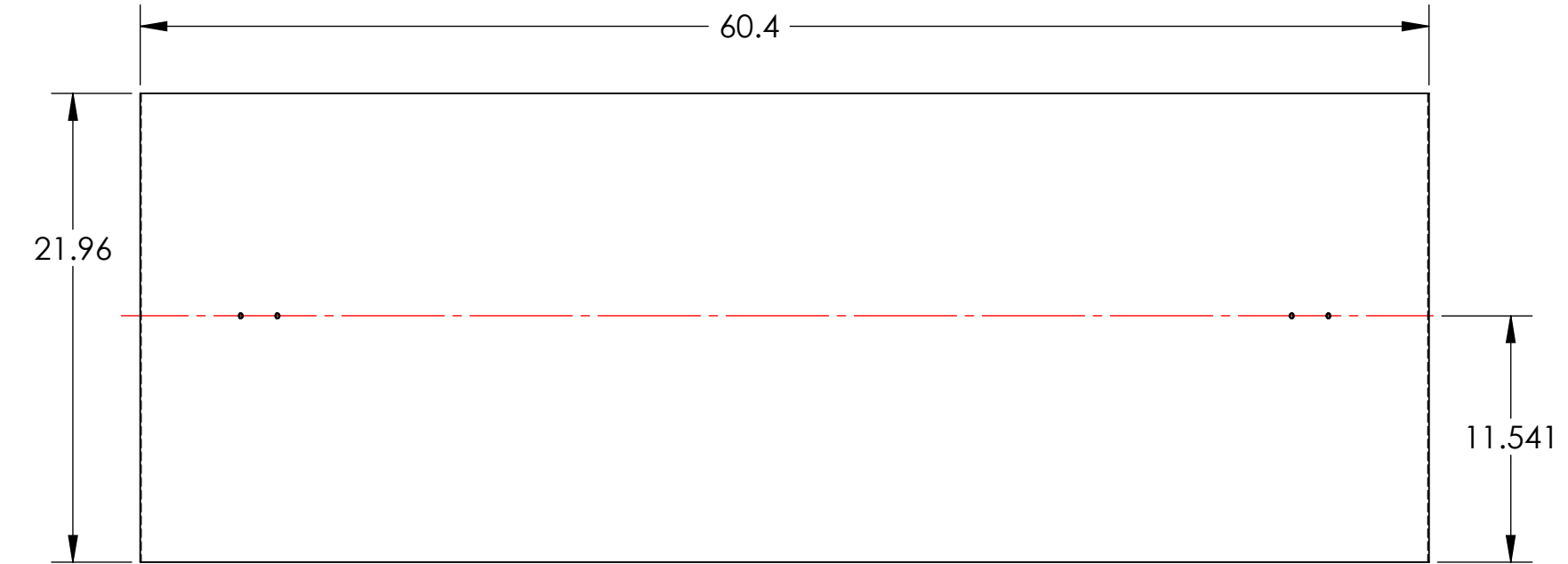
CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS
NEXT ASSY D0902654, D0902655, D0902656	

PART NAME Manifold Cryo Baffle Bracket, Right			
DESIGNER H. KELMAN	DATE 17 MAR 2010	SIZE D	DWG. NO. D0902621
DRAFTER TQ. NGUYEN	DATE 16 AUG 2010	SCALE 1:8	PROJECTION FIRST ANGLE
CHECKER	APPROVAL	REV. v1	SHEET 1 OF 1

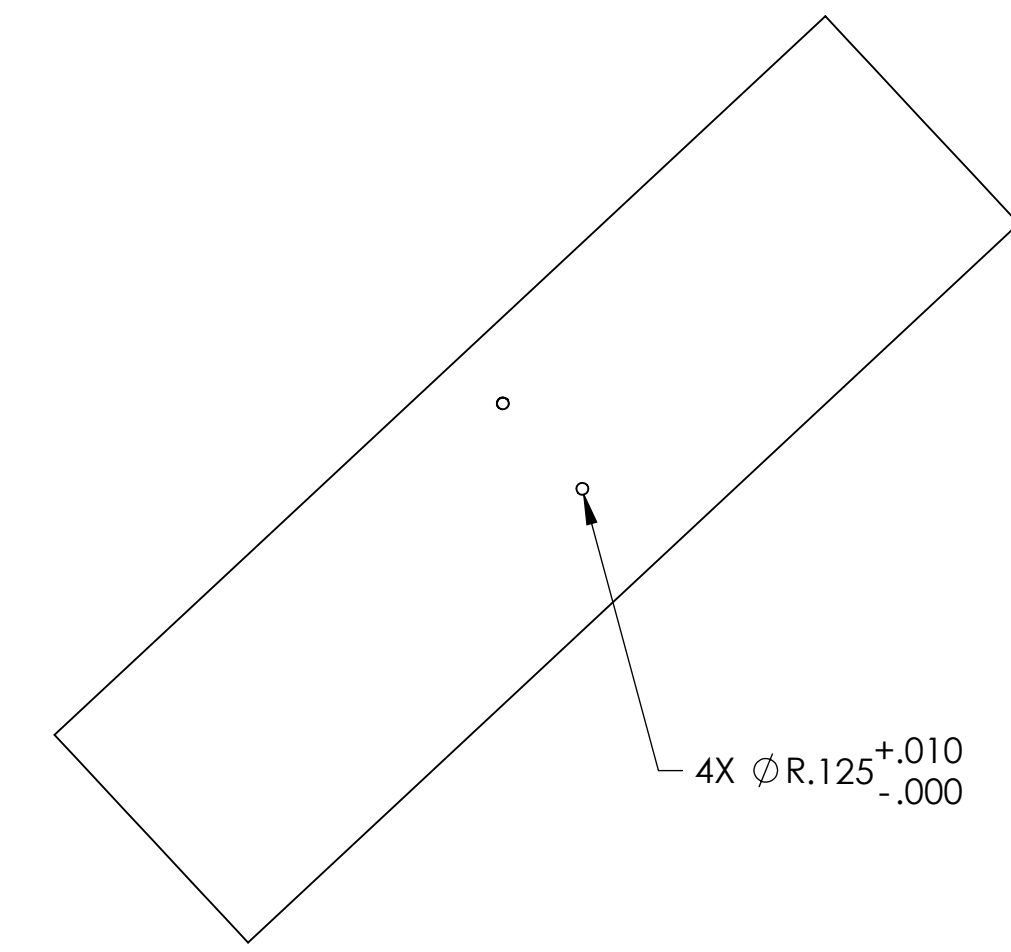
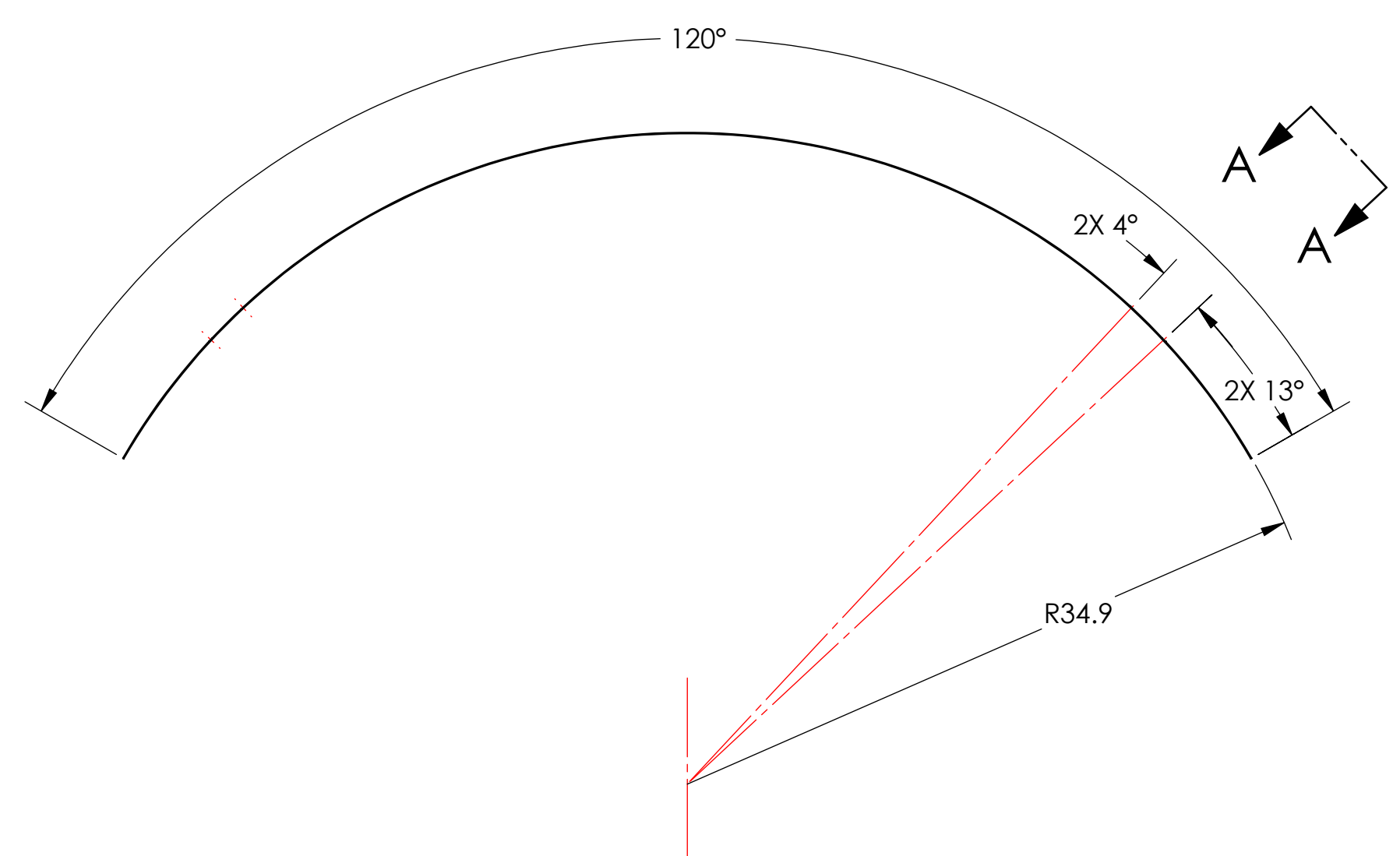
NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

⑥ AS RECEIVED MACHINE FINISH

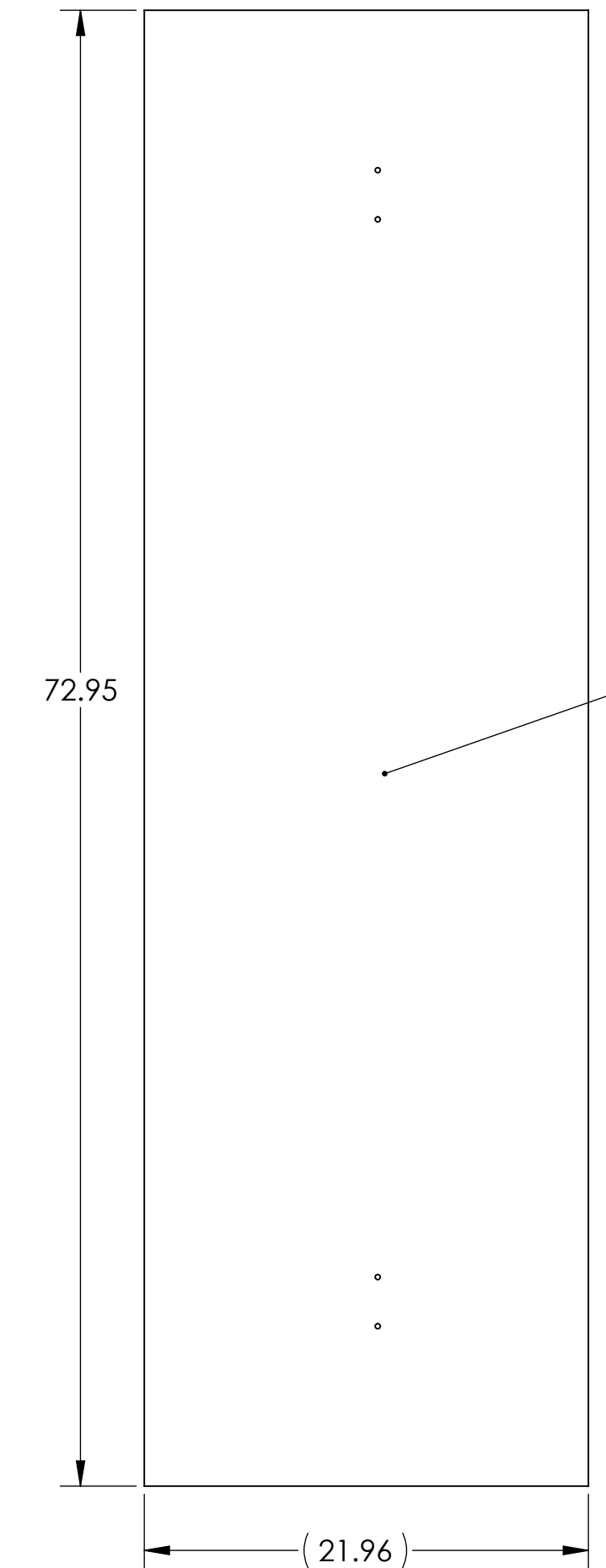
REV.	DATE	DCN #	DRAWING TREE #
V1	03 SEP 2010	E1000360	E1000085
-	-	-	-
-	-	-	-



GENERAL VIEW
FOR REFERENCE ONLY
NO SCALE



SECTION A-A
SCALE 1 : 4



FLAT PATTERN

THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902655 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME			
TOLERANCES: .XX ± .03 .XXX ± .010		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS		RADIAL SEGMENT , BOTTOM	
ANGULAR ± 1.0°		MATERIAL 18GA A424 TYPE 1 STEEL		NEXT ASSY D0902654		DESIGNER H. KELMAN 17 MAR 2010		SIZE DWG. NO. D0902620	
		FINISH ⑥				DRAFTER TQ. NGUYEN 16 AUG 2010		REV. v1	
						CHECKER M. SMITH		SCALE: 1:8 PROJECTION: [Symbol]	
						APPROVAL D. COYNE		SHEET 1 OF 1	

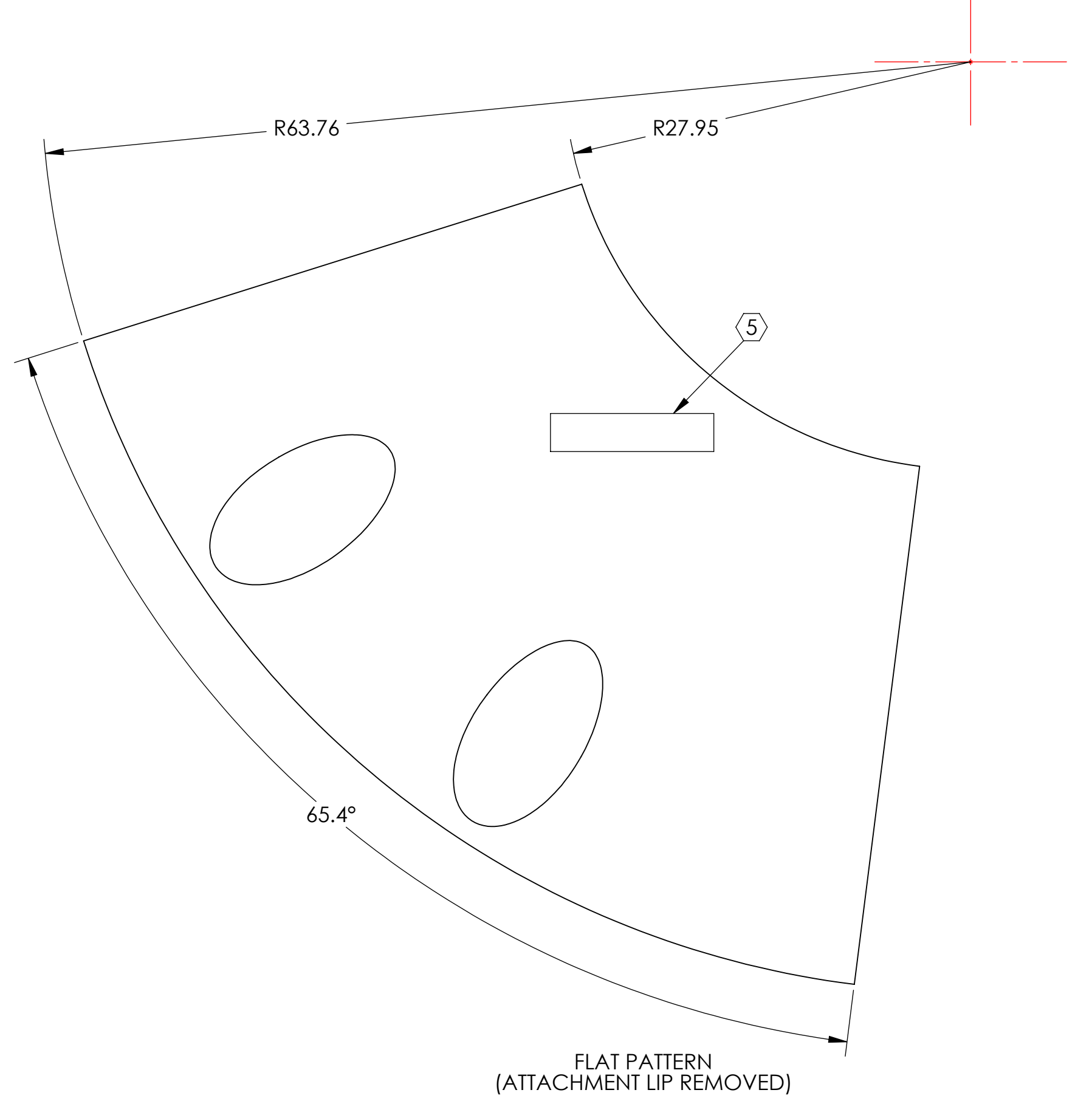
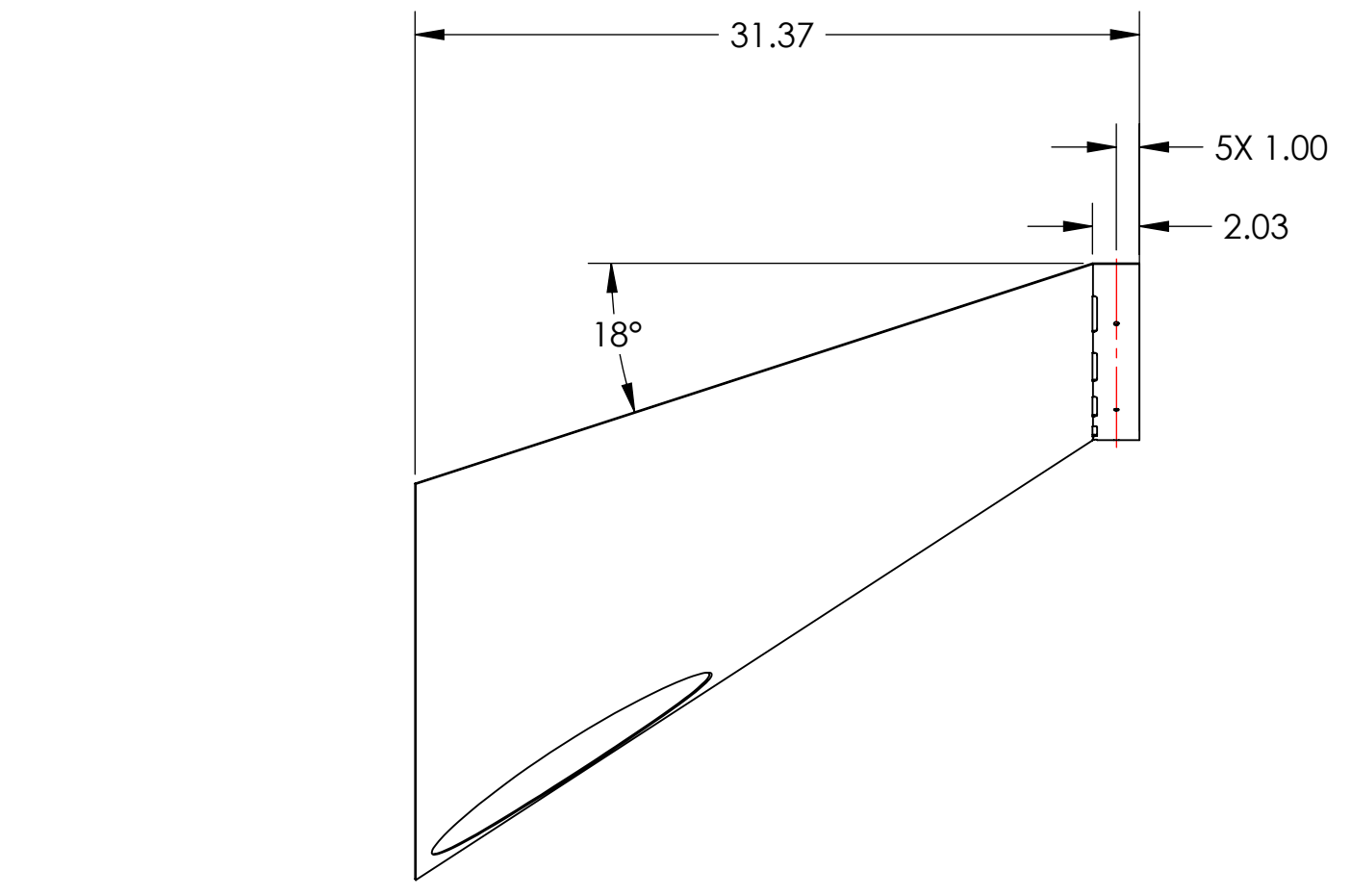
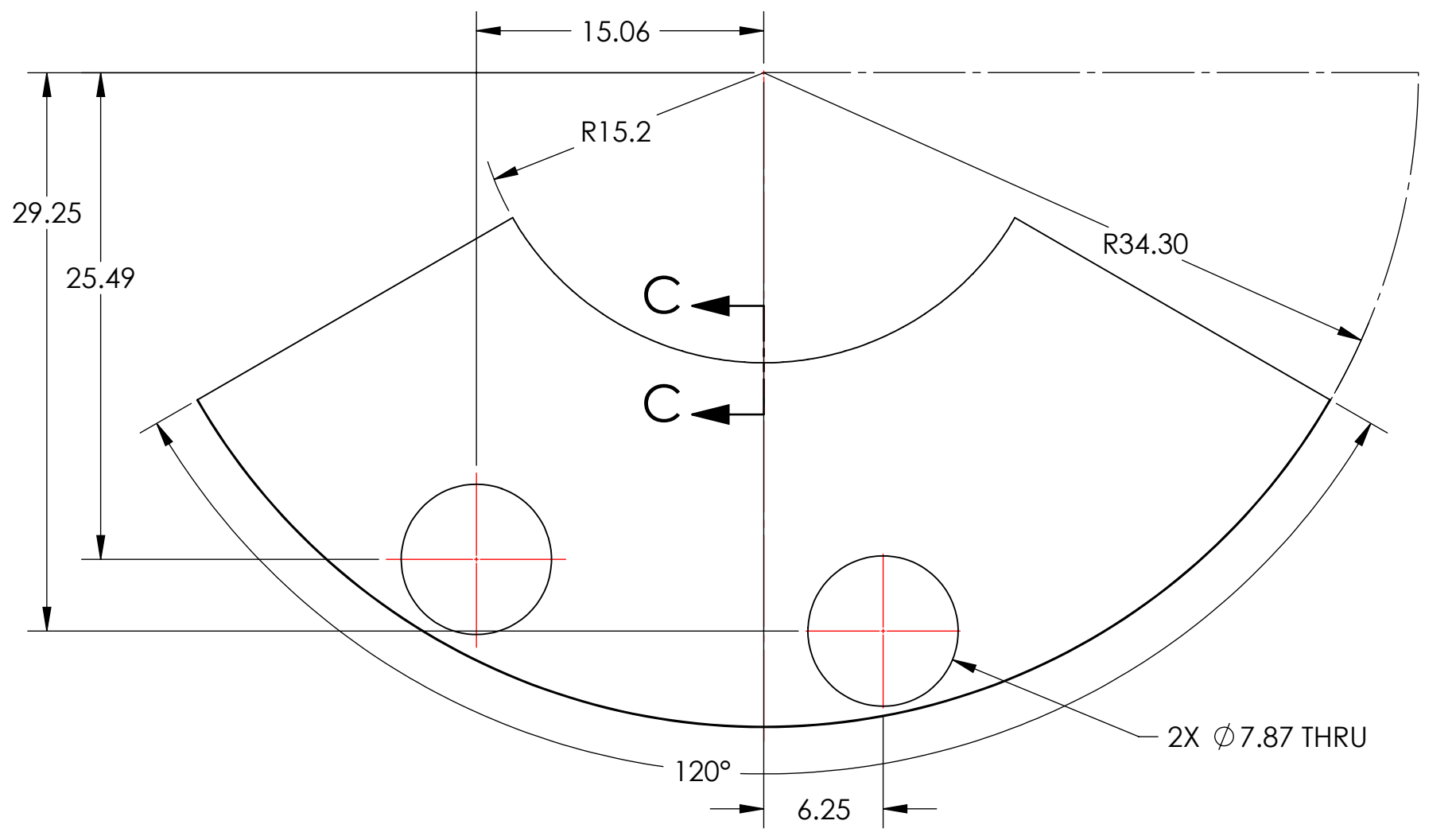
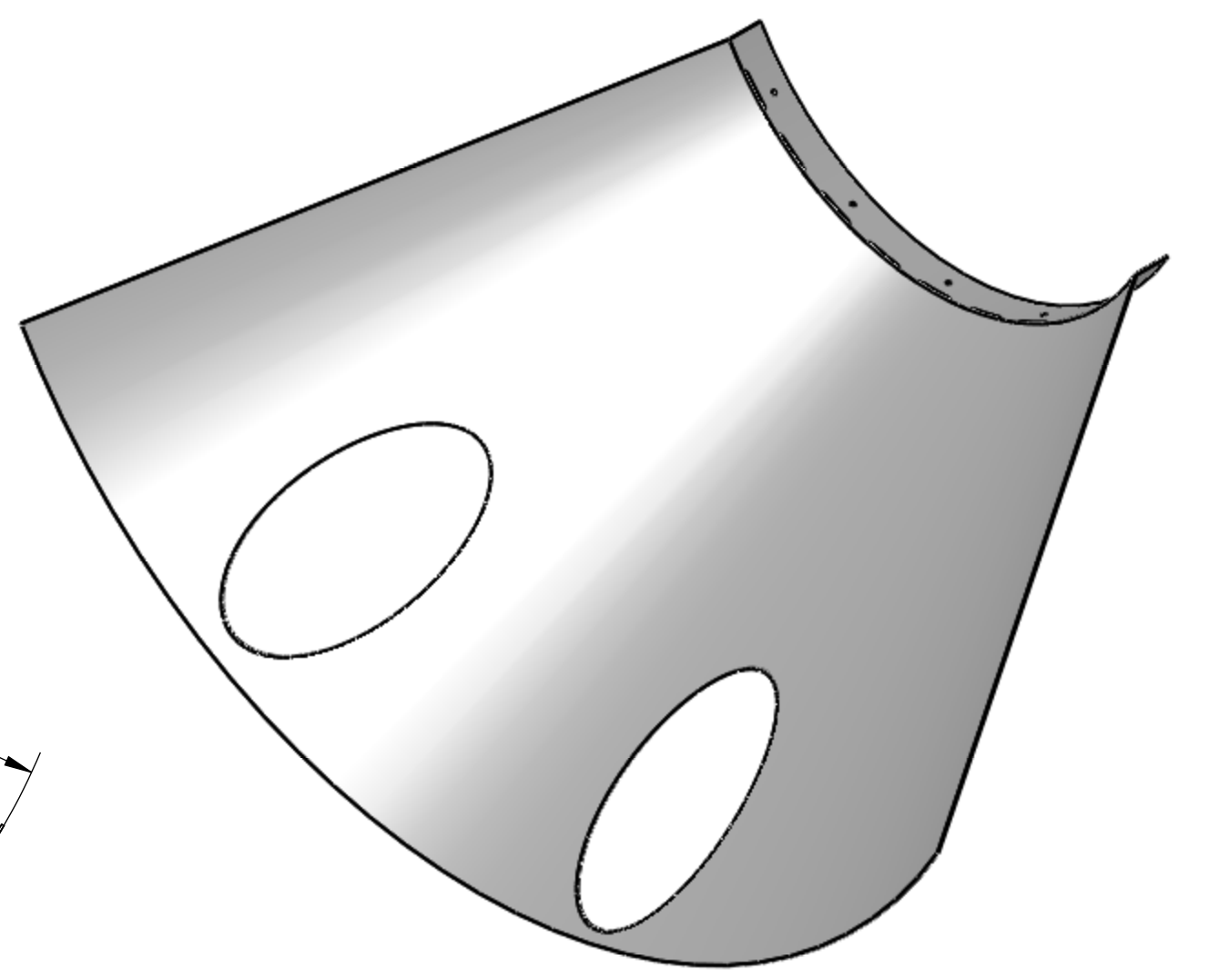
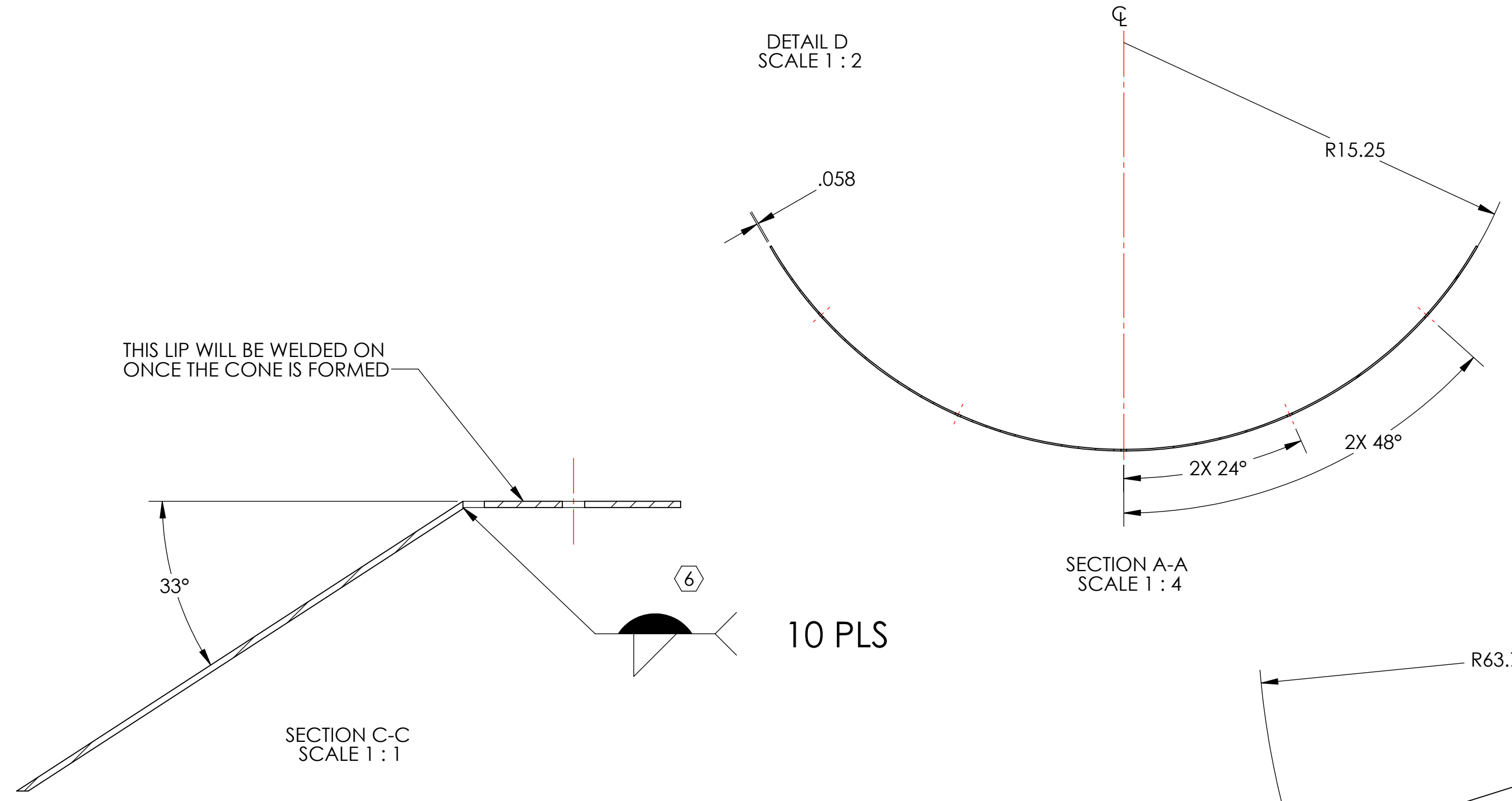
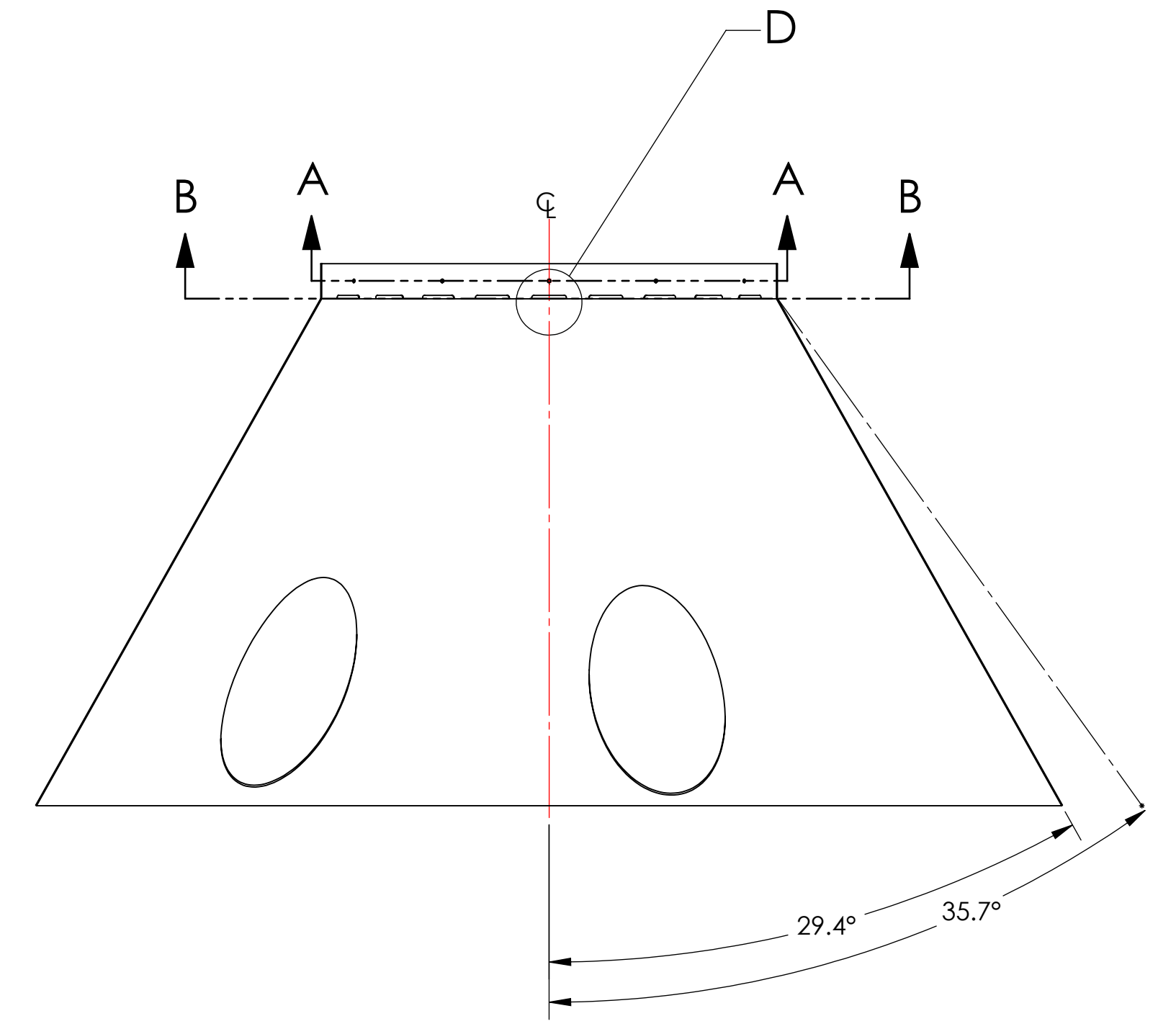
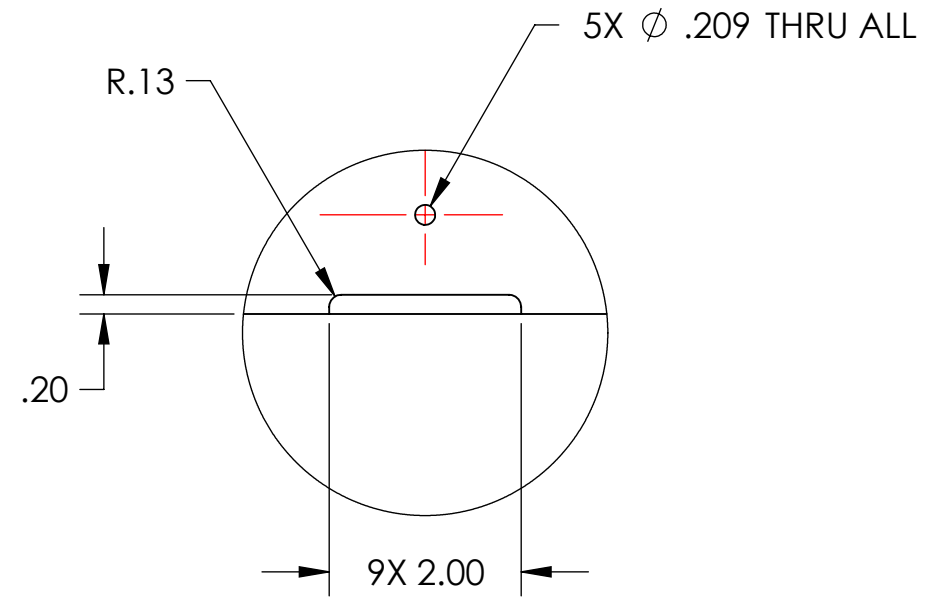
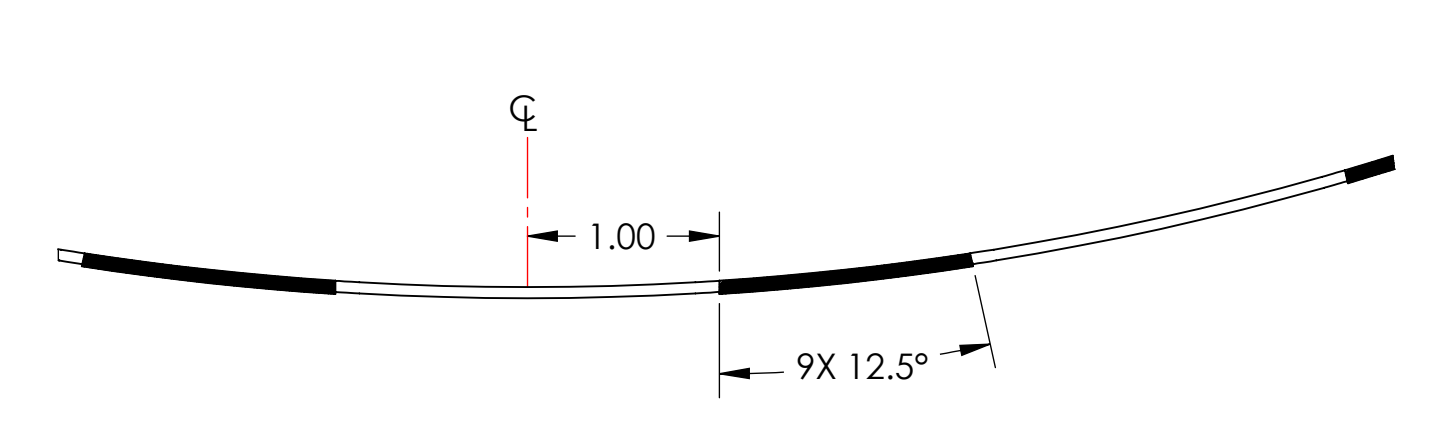
D0902620.dwg; Montfield_Coyne; Radial_Segment; Bottom; PART PDM REV: X-081; DRAWING PDM REV: X-010

NOTES CONTINUED:
 ⑤ SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

⑥ CONE AND LIP TO BE WELDED WHERE PIECES MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.

⑦ MATERIAL AS RECEIVED MACHINE FINISH

REV.	DATE	DCN #	DRAWING TREE #
V1	1 SEP 2010	E1000360	E1000091
-	-	-	-
-	-	-	-



THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902654 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

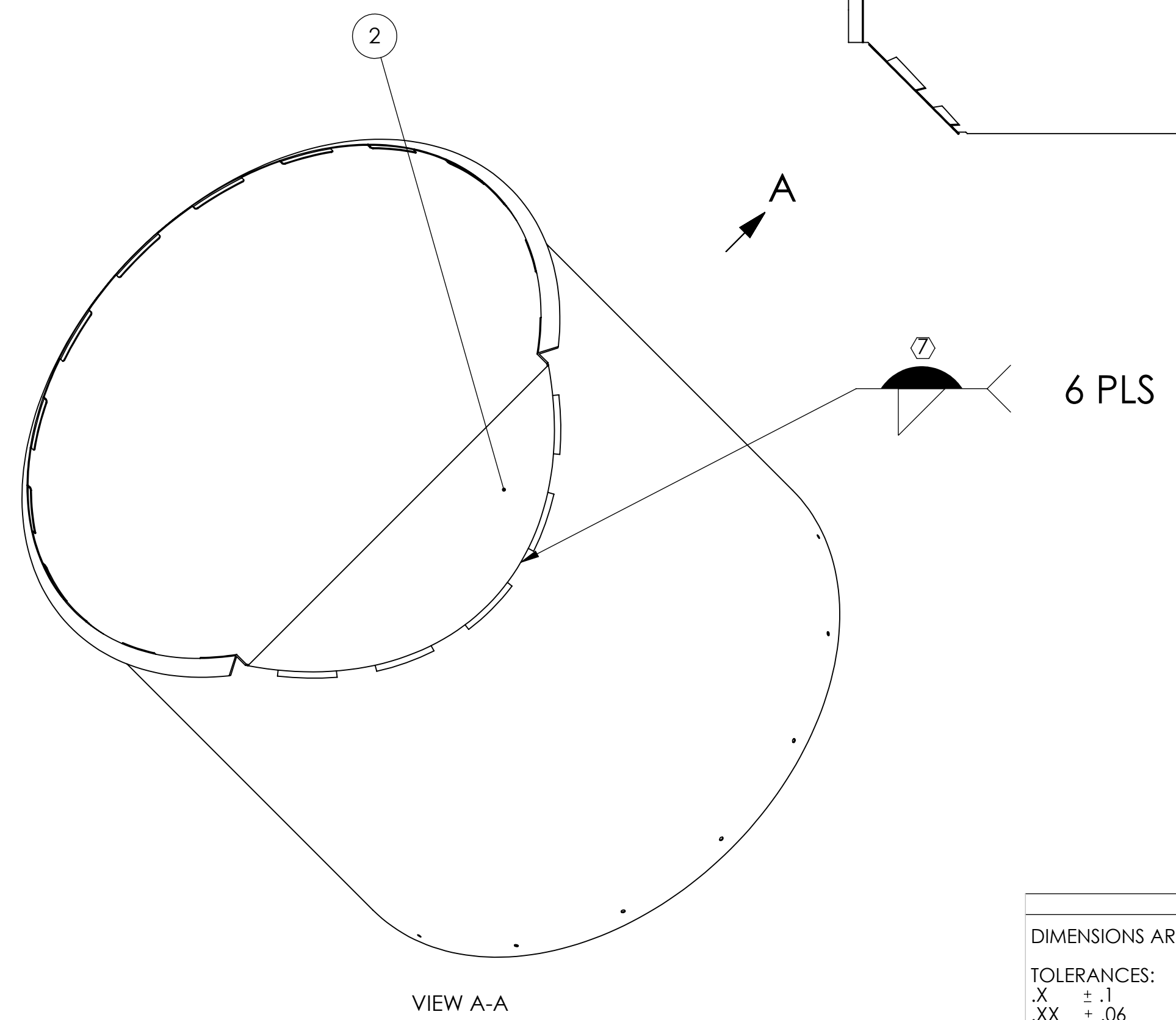
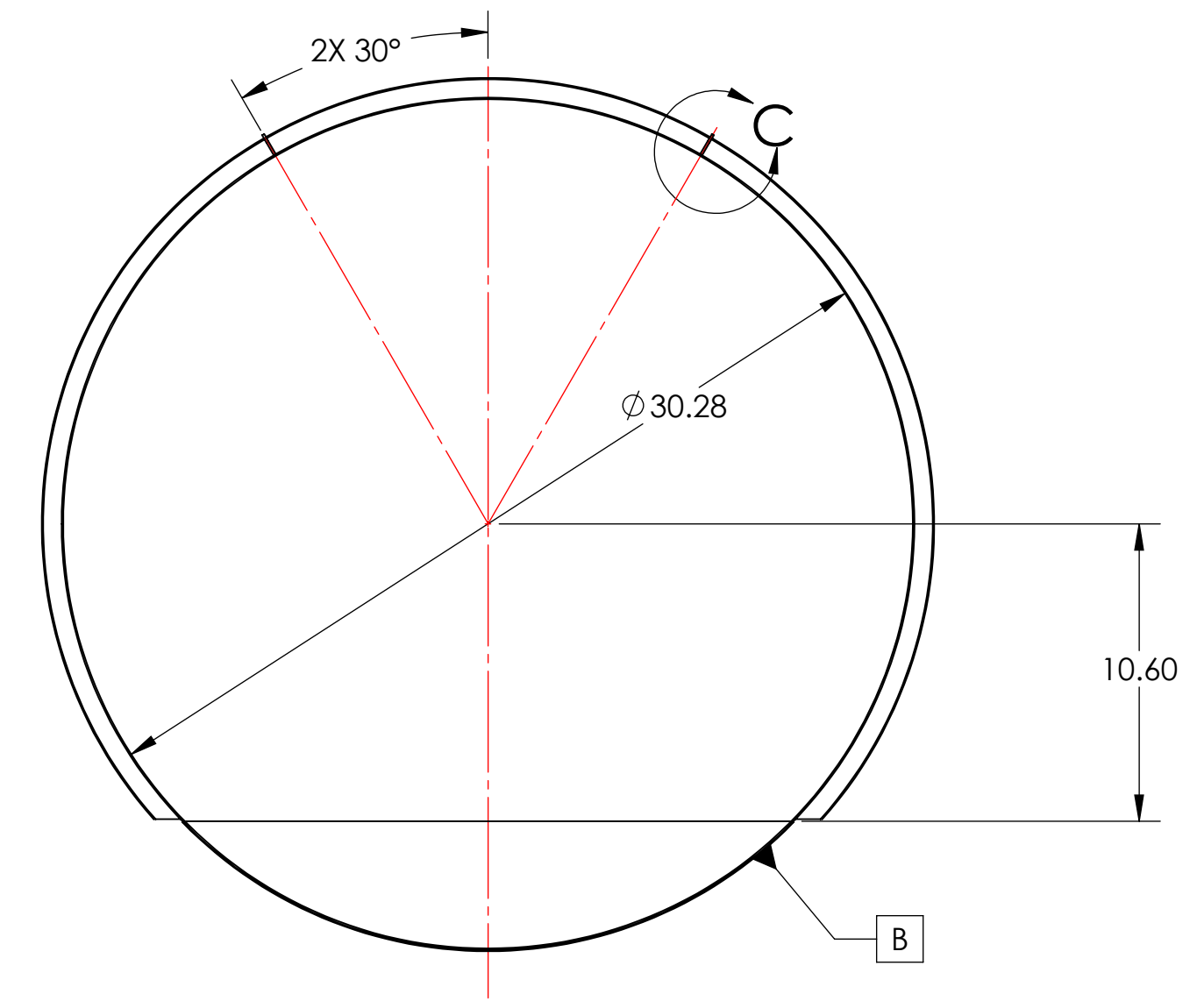
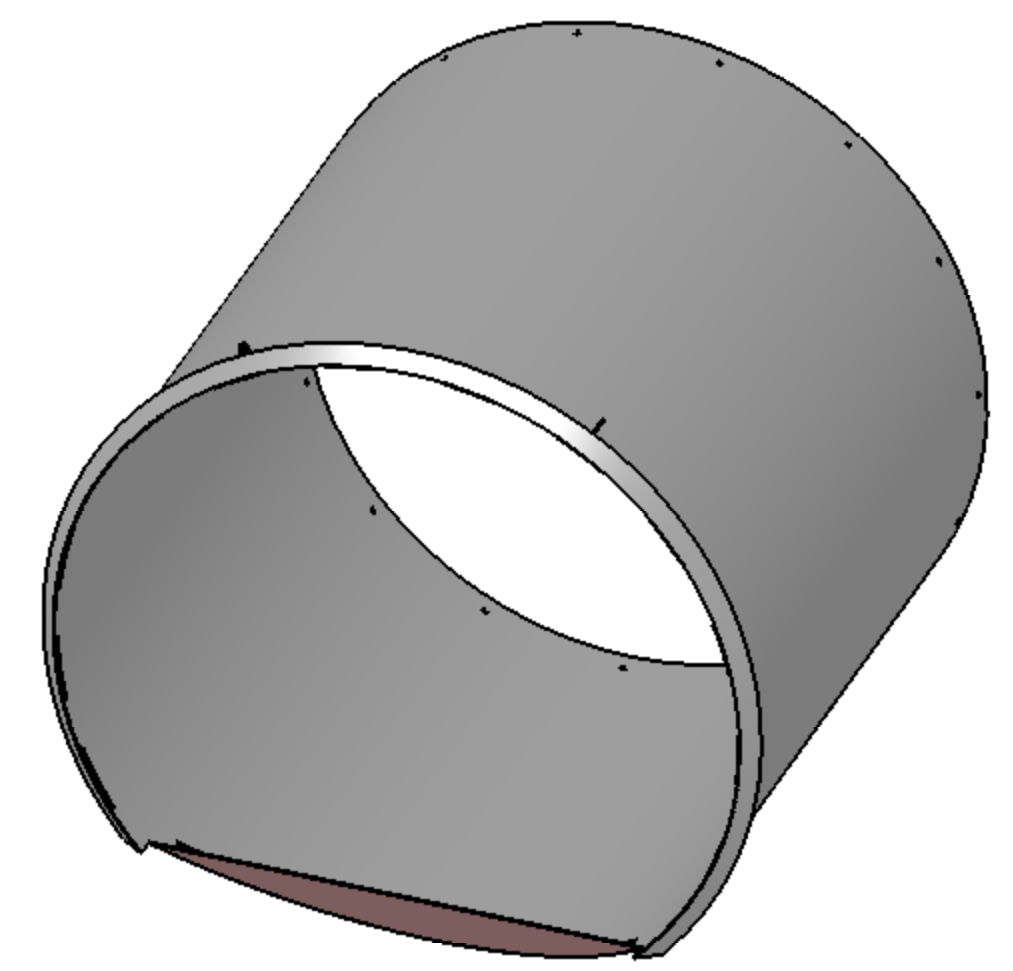
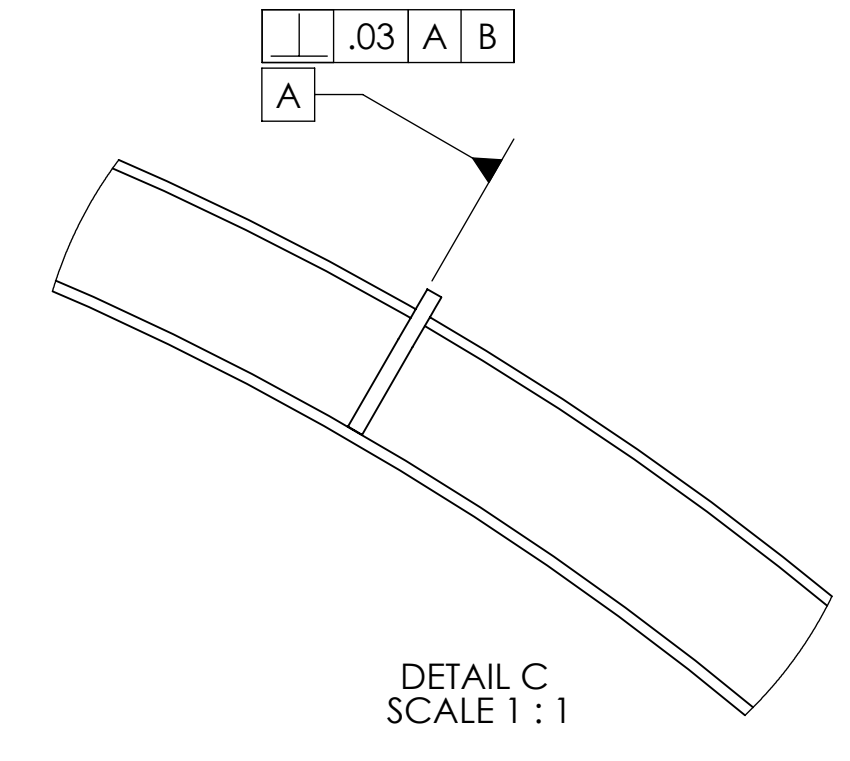
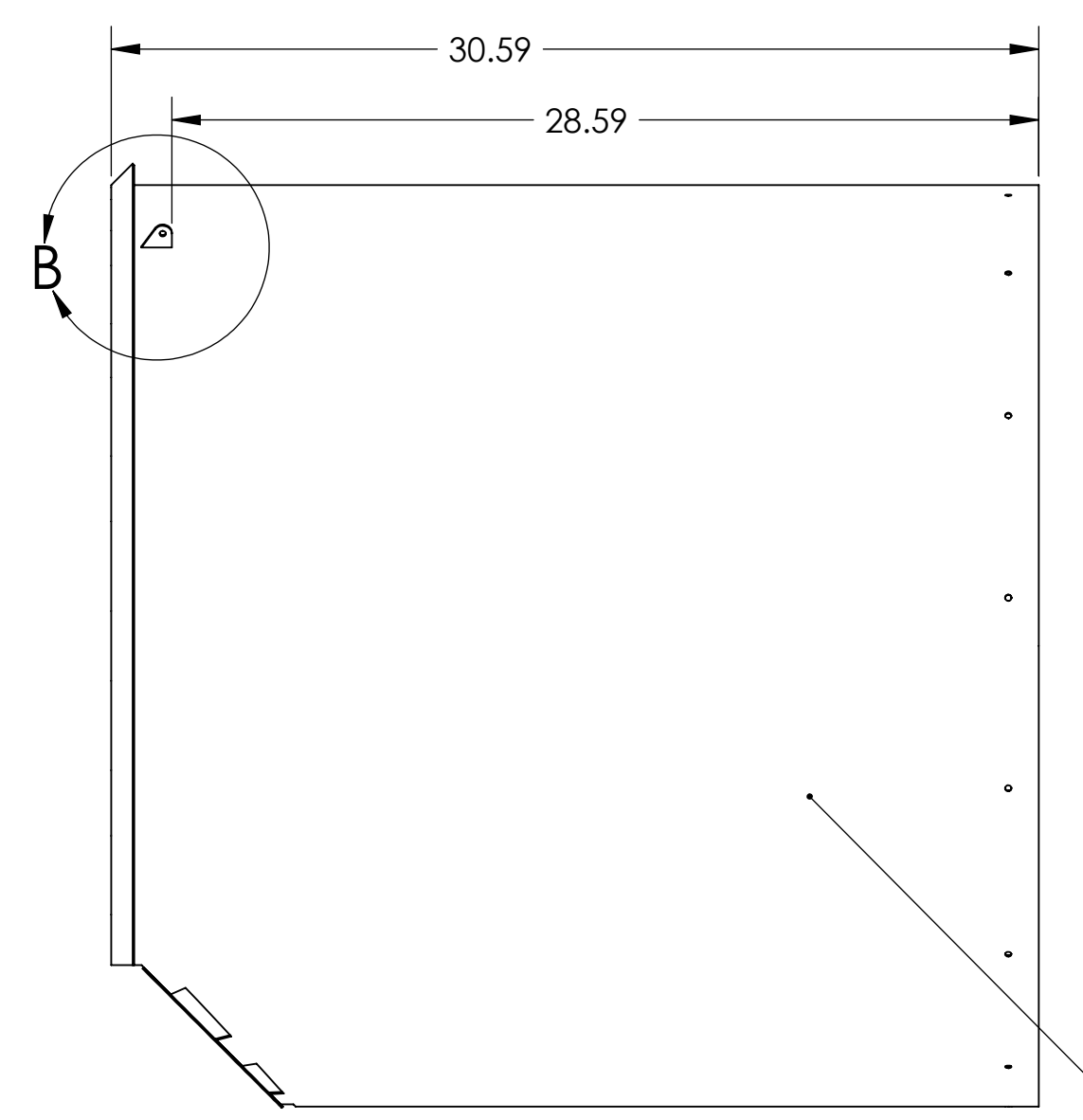
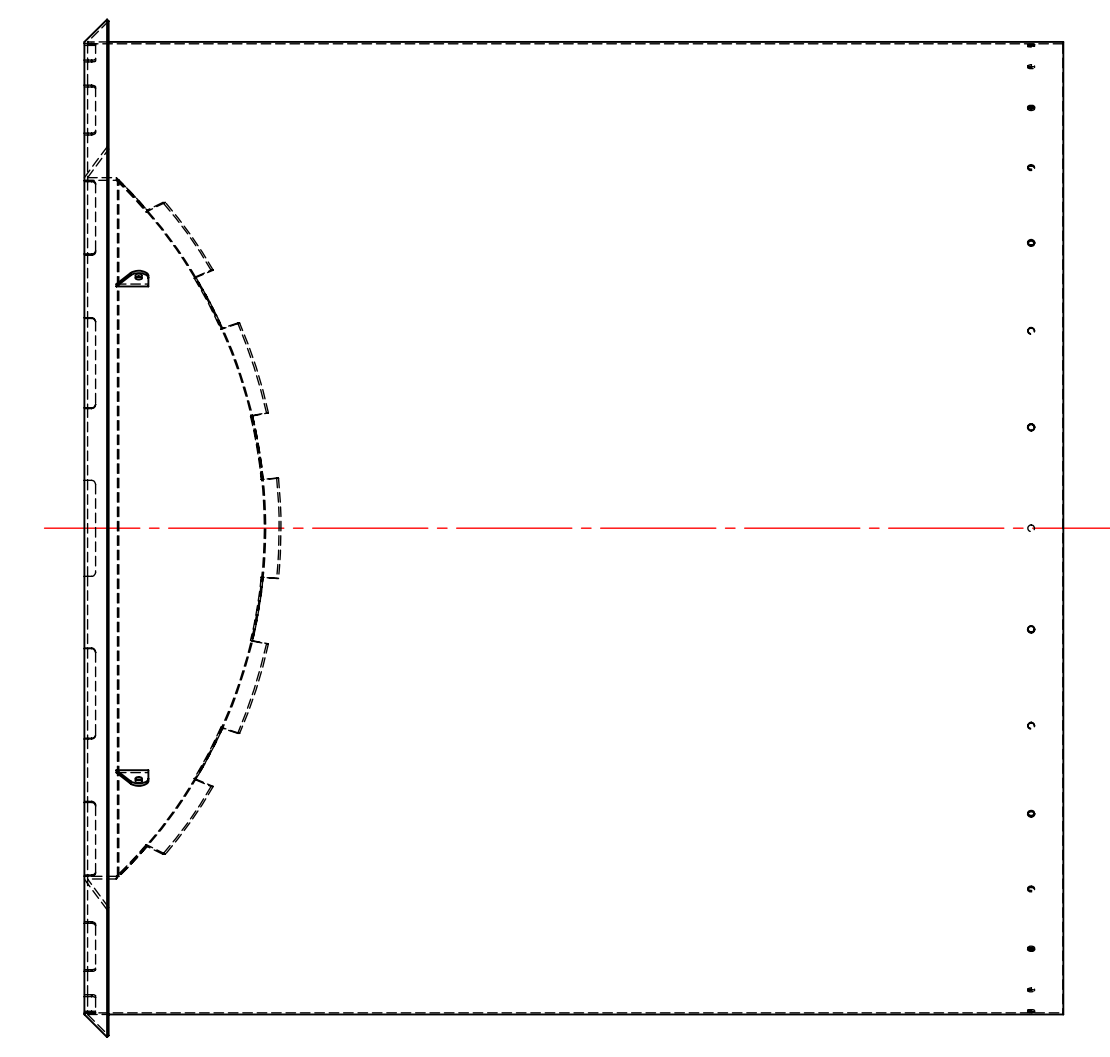
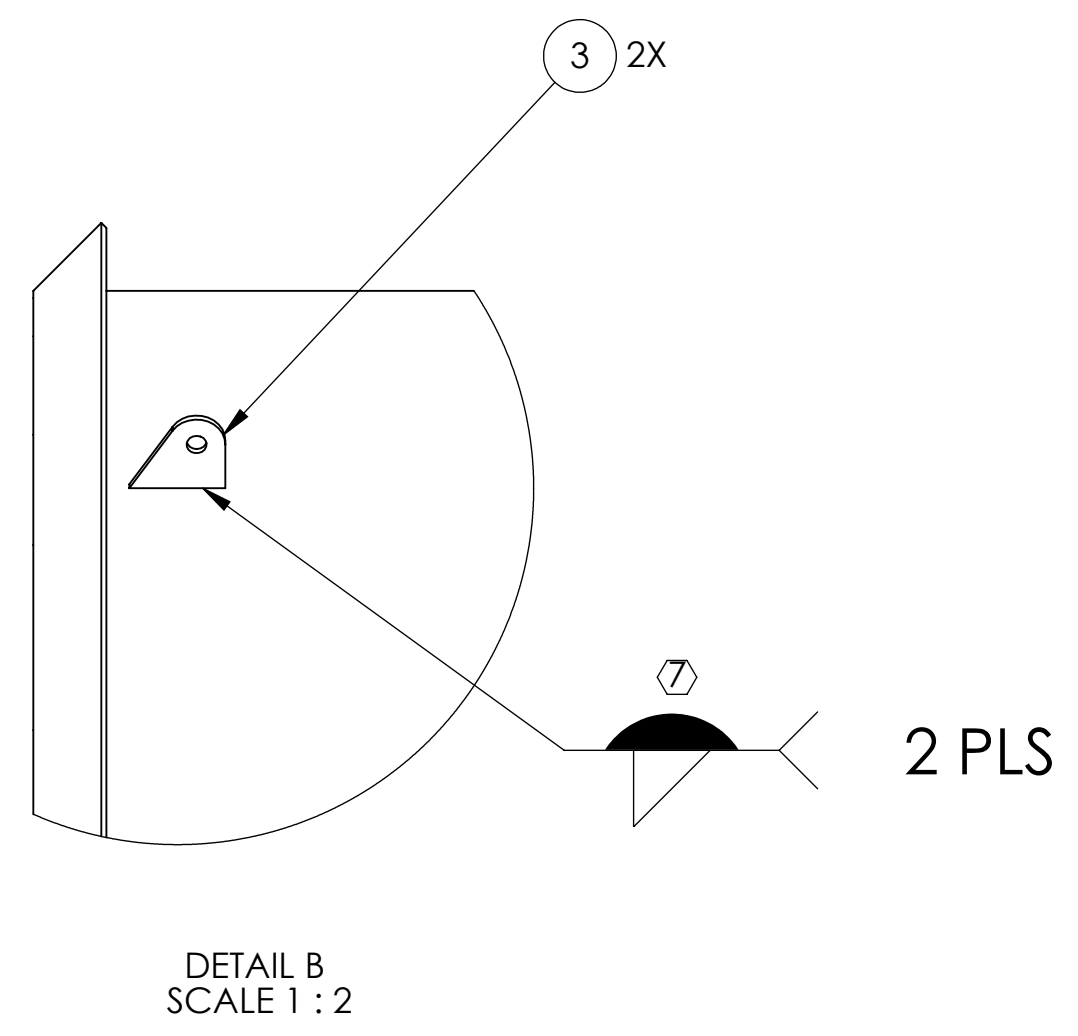
DIMENSIONS ARE IN INCHES		TOLERANCES:		ANGULAR ±0.5°		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		MATERIAL		FINISH		SYSTEM		SUB-SYSTEM		PART NAME		DESIGNER		DRAFTER		CHECKER		APPROVAL		SCALE: 1:8		PROJECTION:		SHEET 1 OF 1	
.XX	± .06	.XXX	± .010			1. INTERPRET DRAWING PER ASME Y14.5-1994.	2. REMOVE ALL SHARP EDGES, R.02 MIN.	3. DO NOT SCALE FROM DRAWING.	4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.	18GA A424 TYPE I STEEL	⑦	ADVANCED LIGO	AOS	MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ITMX H1-H2, RIGHT	H. KELMAN	12 MAY 2010	TQ. NGUYEN	17 AUG 2010	M. SMITH	D	D0902619	v1									

D:\0902619\alUGO_Manifold_Cryo_Baffle_Inner_Segment\ITMX_H1-H2_RIGHT_PART_PDM\REV-X-019_DRAWING_PDM\REV-X-019

NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER, SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
 EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

6. ASSEMBLY WILL BE PORCELAIN COATED AFTER WELDMENT IS COMPLETED.
 7. FILLET WELD WHERE ITEMS 1 & 3 AND 1 & 2 MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E 0900048

REV.	DATE	DCN #	DRAWING TREE #
V1	20 MAY 2010	E1000360	E1000367
-	-	-	-
-	-	-	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
3	D1000536	Baffle Brace Bracket	14GA A424 TYPE I STEEL	2		2
2	D1001018	ELLIPSE SCRAPER BLADE	14GA A424 TYPE I STEEL	1		1
1	D1000570	MANIFOLD-CRYO BAFFLE CYLINDER	18GA A424 TYPE I STEEL	1		1

DIMENSIONS ARE IN INCHES		NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)		CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010		1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		SYSTEM ADVANCED LIGO		SUB-SYSTEM AOS	
ANGULAR ± 1.0°		MATERIAL N/A		FINISH N/A		PART NAME MANIFOLD-CRYO BAFFLE CYLINDER-SCRAPER ASSEMBLY	
		NEXT ASSY D1002061		DESIGNER H. KELMAN 25 MAY 2010		SIZE DWG. NO. D D1001348	
				DRAFTER TQ. NGUYEN 07 SEP 2010		REV. v1	
				CHECKER M. SMITH		SCALE: 1:6 PROJECTION:	
				APPROVAL D. COYNE		SHEET 1 OF 1	

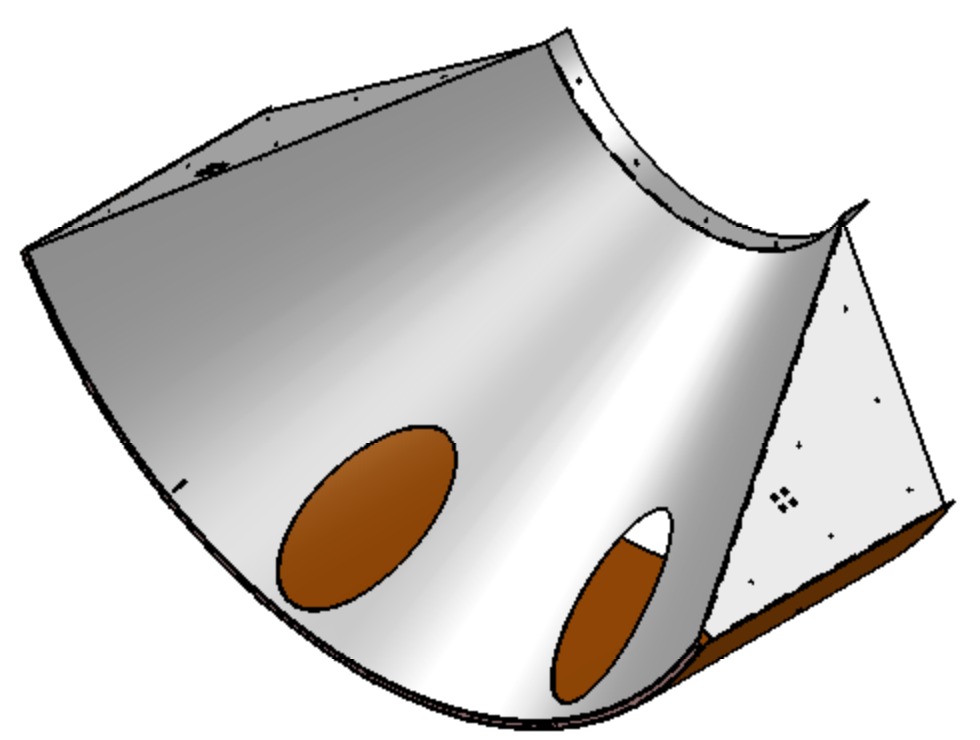
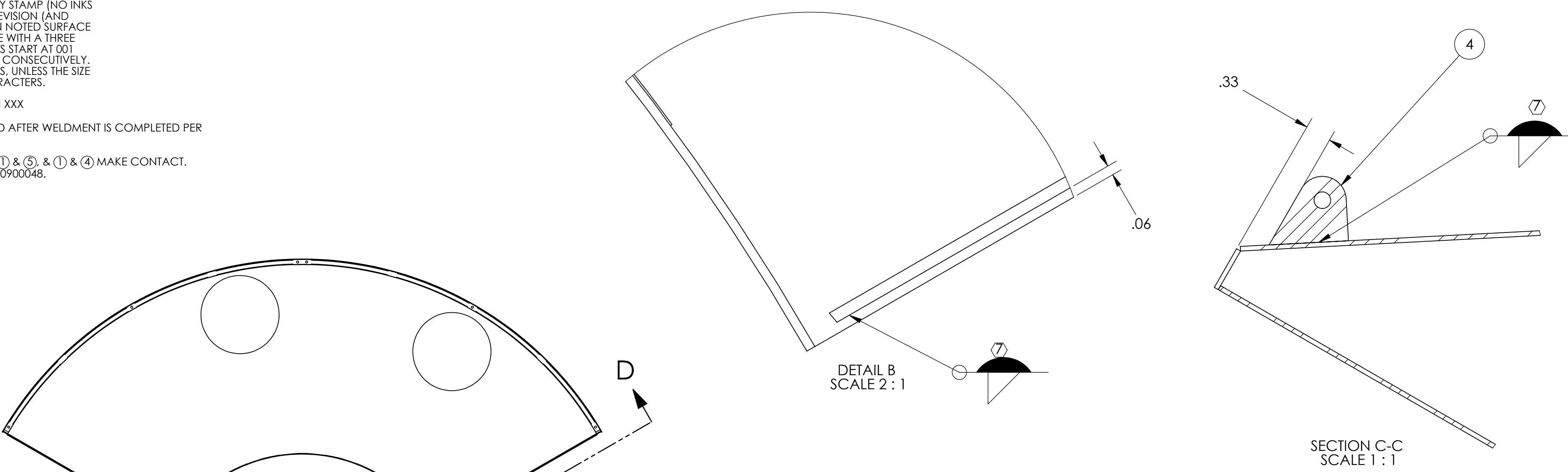
D1001348.dwg: Manifold_Cryo_Baffle_Cyl_Scraper Assy: PART PDM REV: X-017: DRAWING PDM REV: X-005

REV.	DATE	DCN #	DRAWING TREE #
V1	20 MAY 2010	E1000360	E1000090
-	-	-	-
-	-	-	-

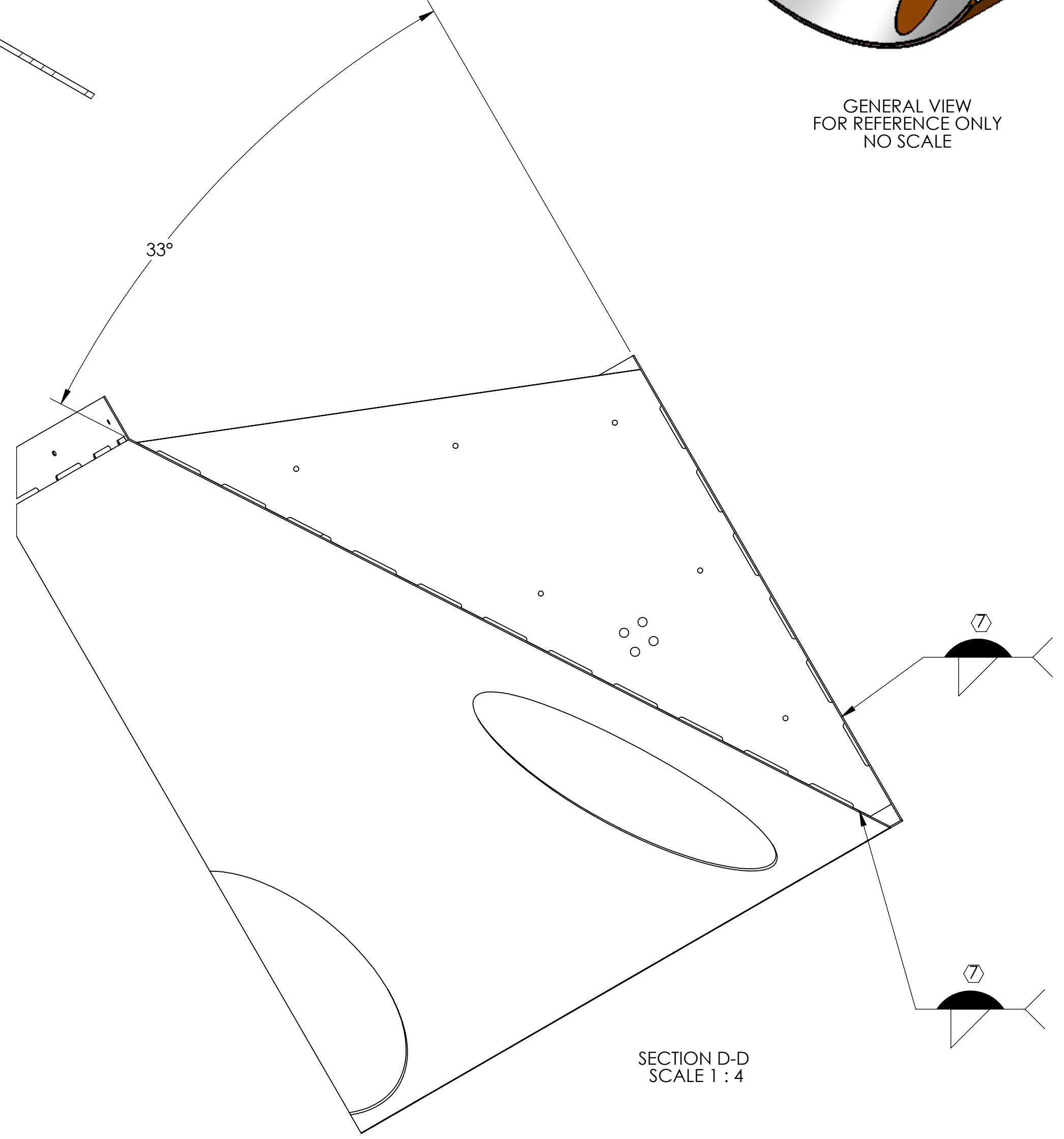
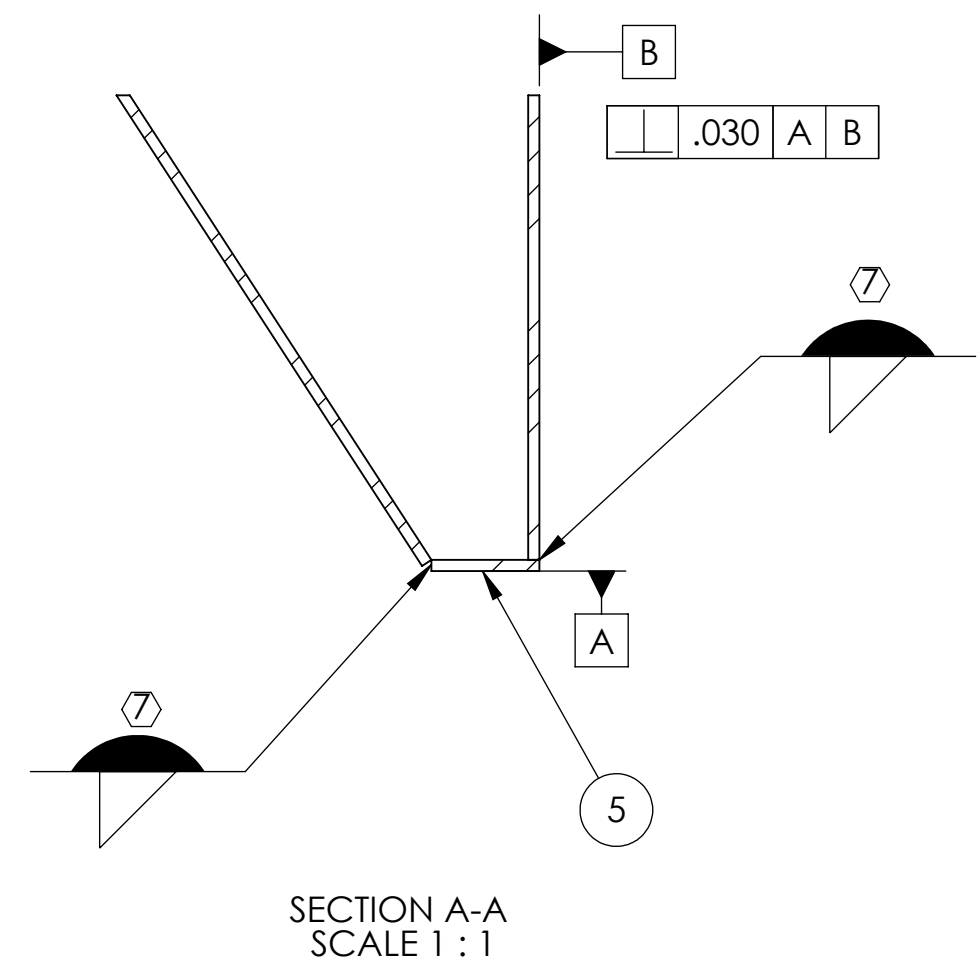
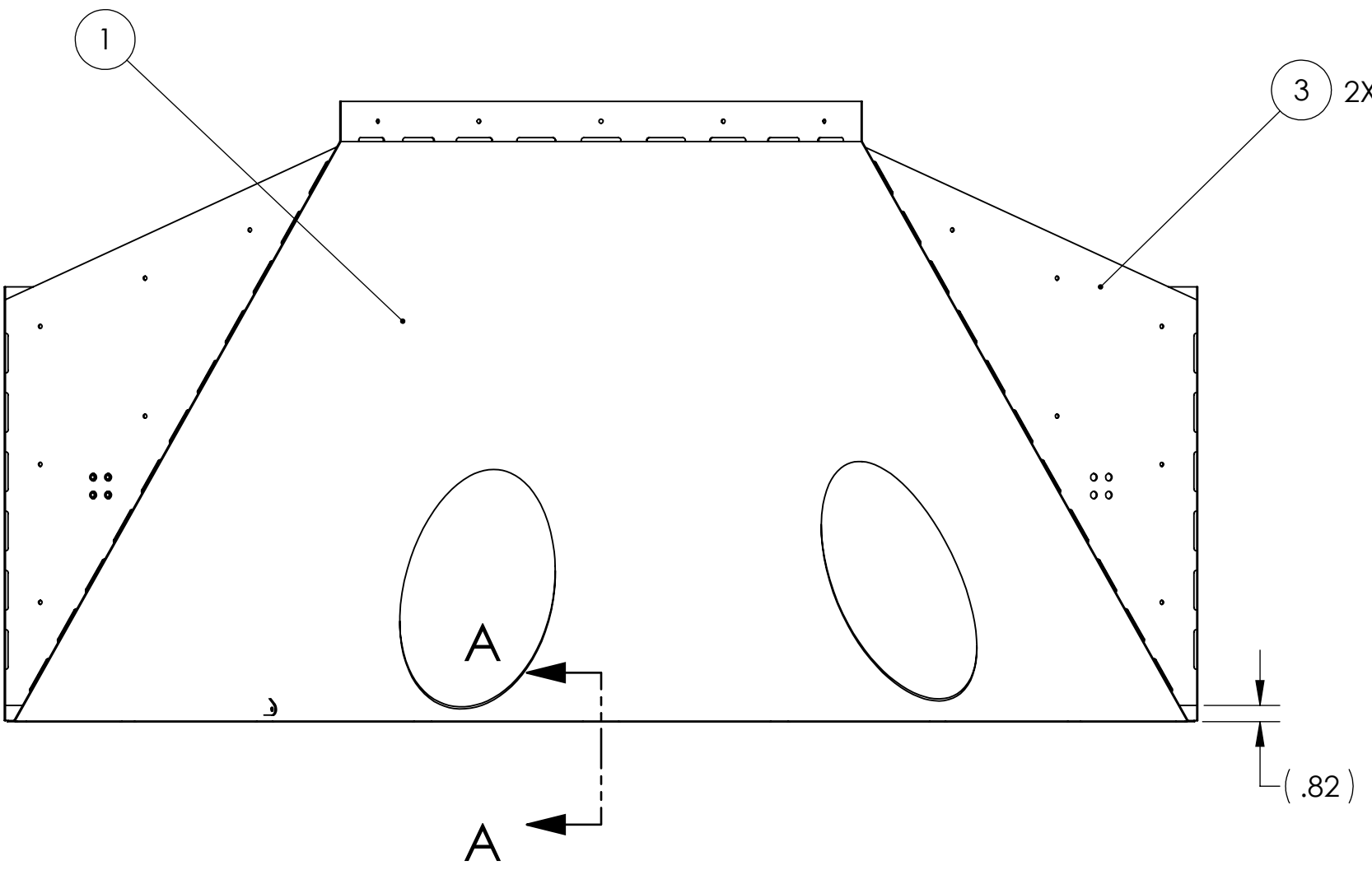
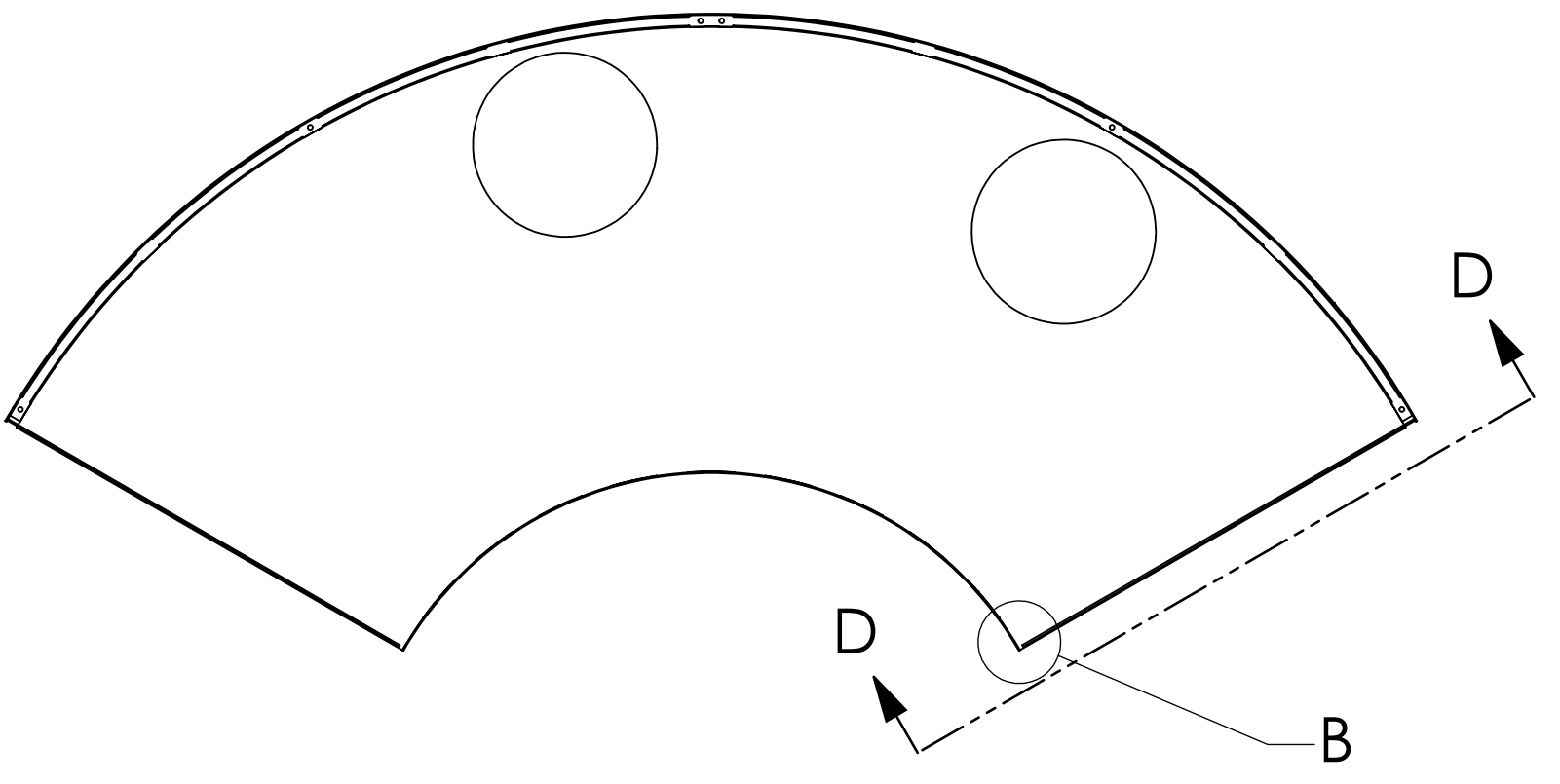
NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
 EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

6. ASSEMBLY TO BE PORCELAIN COATED AFTER WELDMENT IS COMPLETED PER SPECIFICATION E1000083

7. FILLET WELDS WHERE ITEMS 1 & 3, 1 & 5, & 1 & 4 MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048.

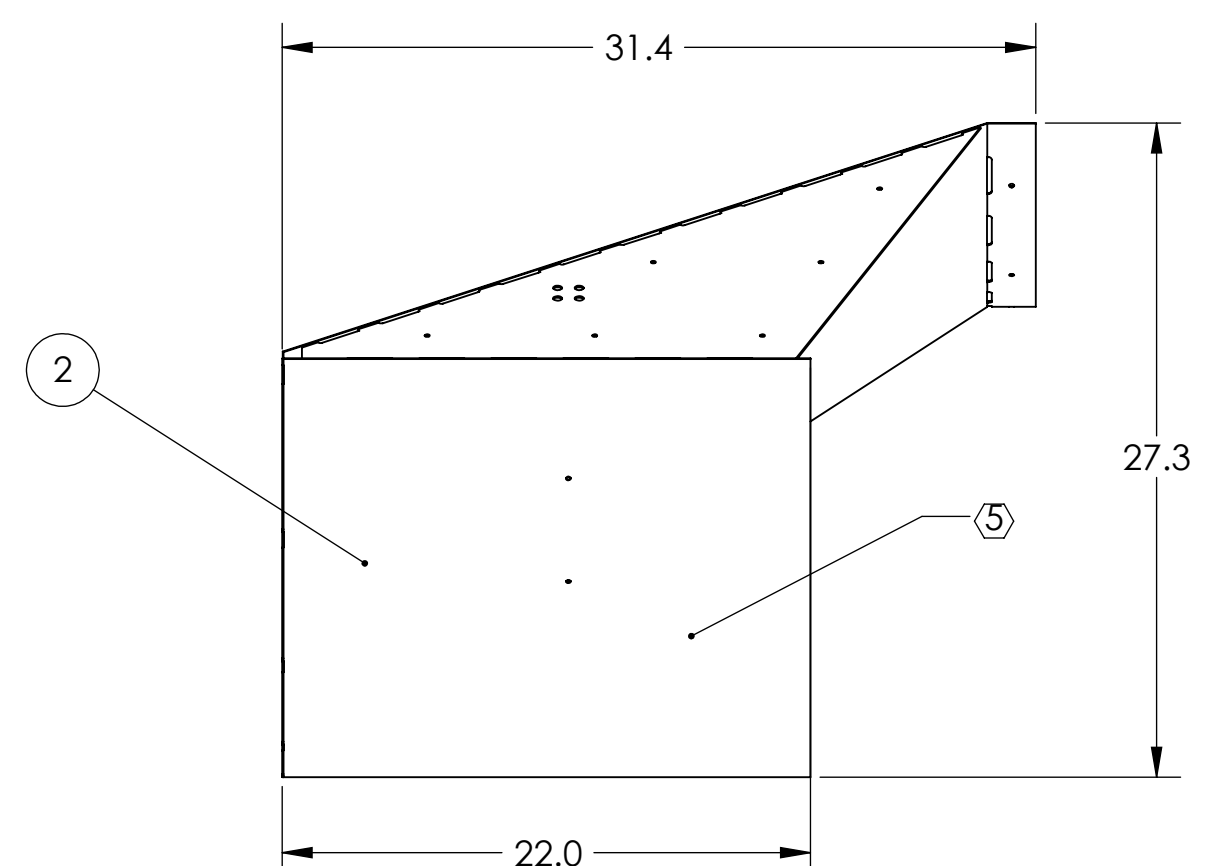
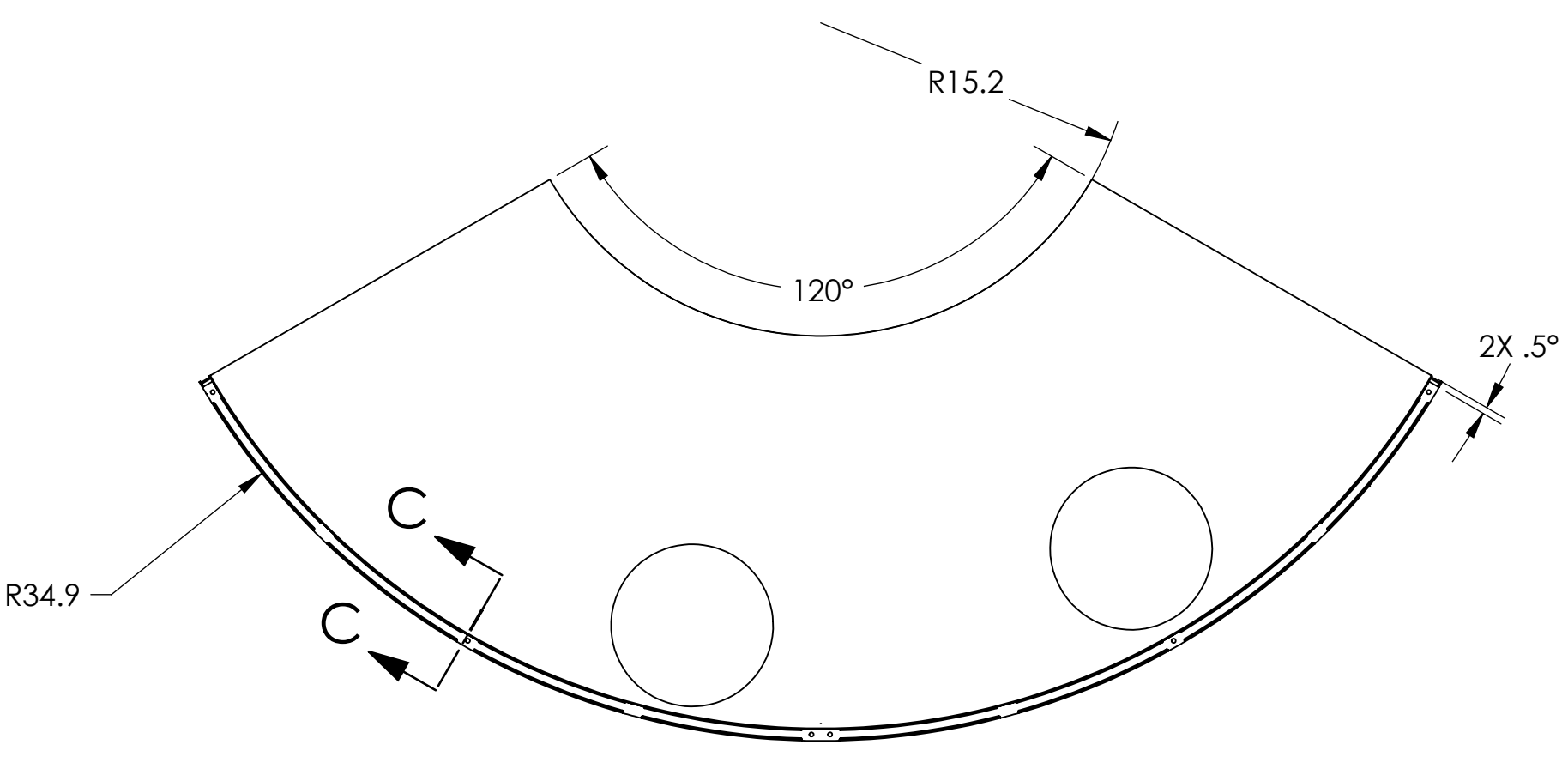


GENERAL VIEW FOR REFERENCE ONLY NO SCALE



7 PLS

12 PLS



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
5	D1001073	RADIAL ATTACHMENT NUT PLATE	14GA A424 TYPE I STEEL	1		1
4	D1000536	Baffle Brace Bracket	14GA A424 TYPE I STEEL	1		1
3	D0902621	Manifold Cryo Baffle Bracket, Right	14GA A424 TYPE I STEEL	2		2
2	D1000558	RADIAL SEGMENT, LEFT	18GA A424 TYPE I STEEL	1		1
1	D0902622	MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ITMX H1-H2, LEFT	18GA A424 TYPE I STEEL	1		1

THIS PIECE IS PART OF A WELDMENT. DIMENSIONS SHOWN ARE APPROXIMATE; WELD INDUCED SHRINKAGE OR FILL, AND POST WELD ANNEALING AND MACHINING CONSIDERATIONS ARE NOT INCLUDED. SEE D0902654 FOR REQUIRED DIMENSIONS FOR STRUCTURE AFTER WELDMENT.

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010	
ANGULAR ± 1.0°	
MATERIAL	N/A
FINISH	N/A

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: ADVANCED LIGO SUB-SYSTEM: AOS

PART NAME: MANIFOLD-CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ITMX H1-H2, LEFT

DESIGNER: H. KELMAN DATE: 20 MAY 2010 SIZE: D DWG. NO.: D0902656 REV.: v1
 DRAFTER: TQ. NGUYEN DATE: 07 SEP 2010
 CHECKER: M. SMITH
 APPROVAL: D. COYNE

SCALE: 1:8 PROJECTION: SHEET 1 OF 1

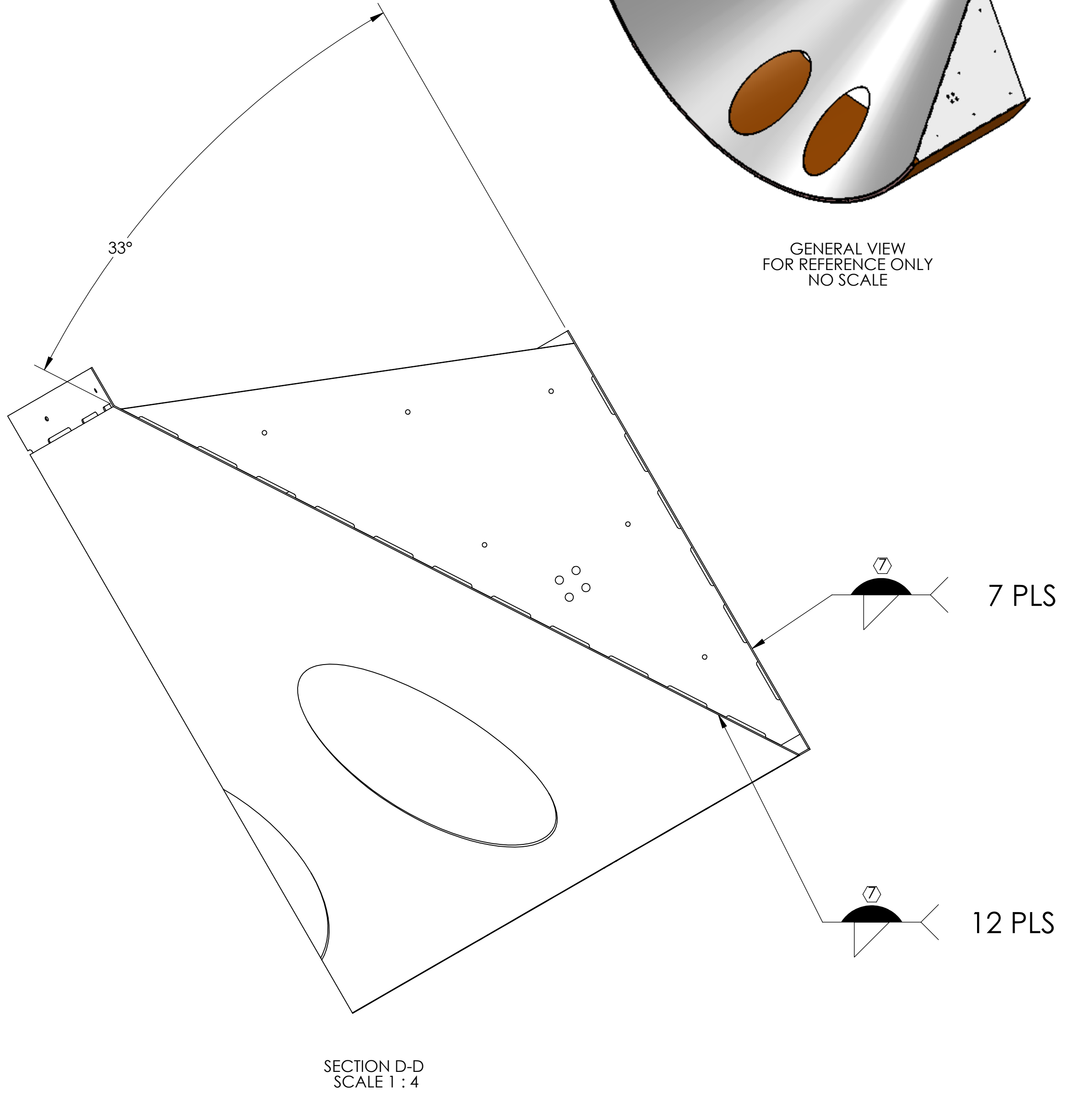
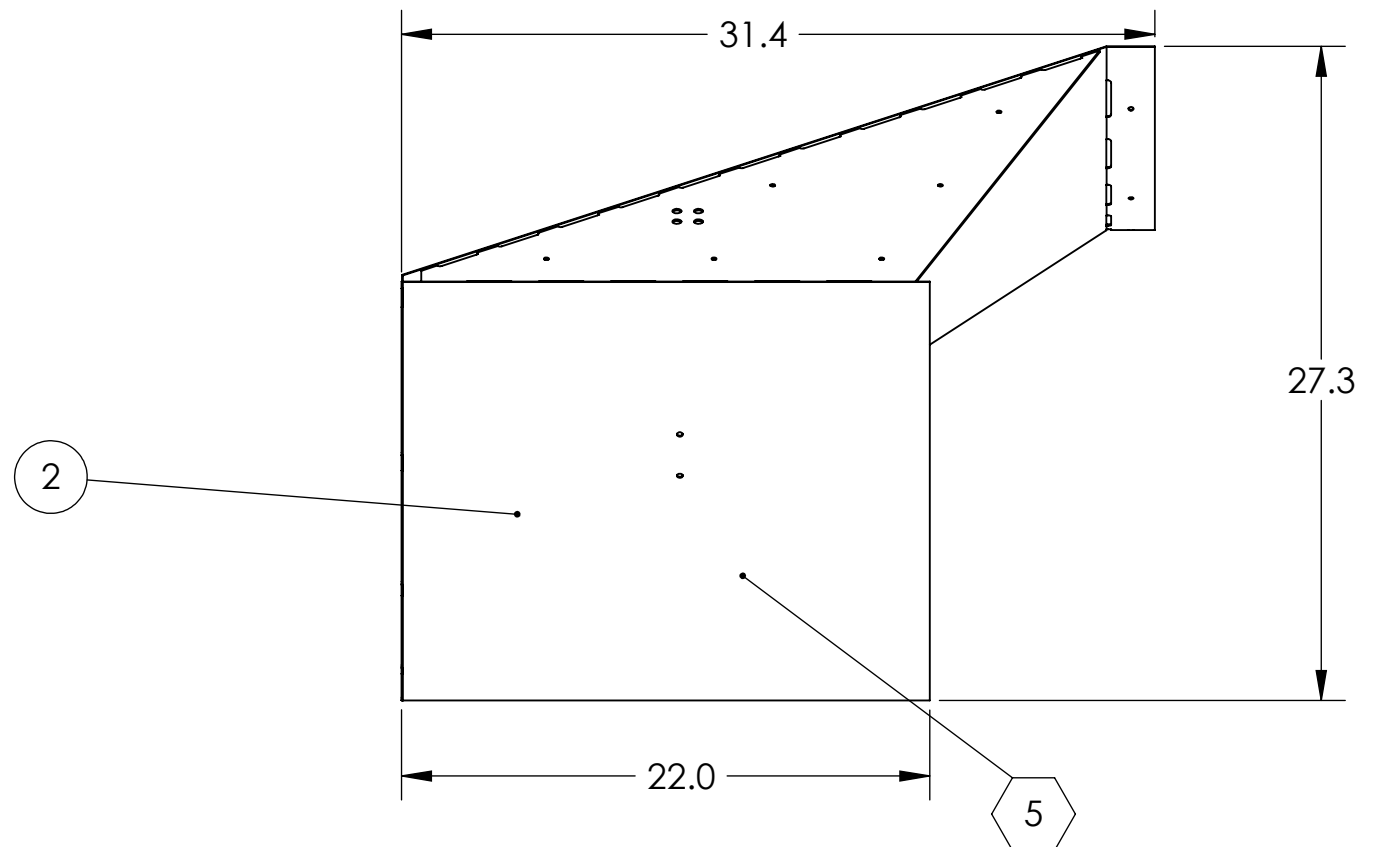
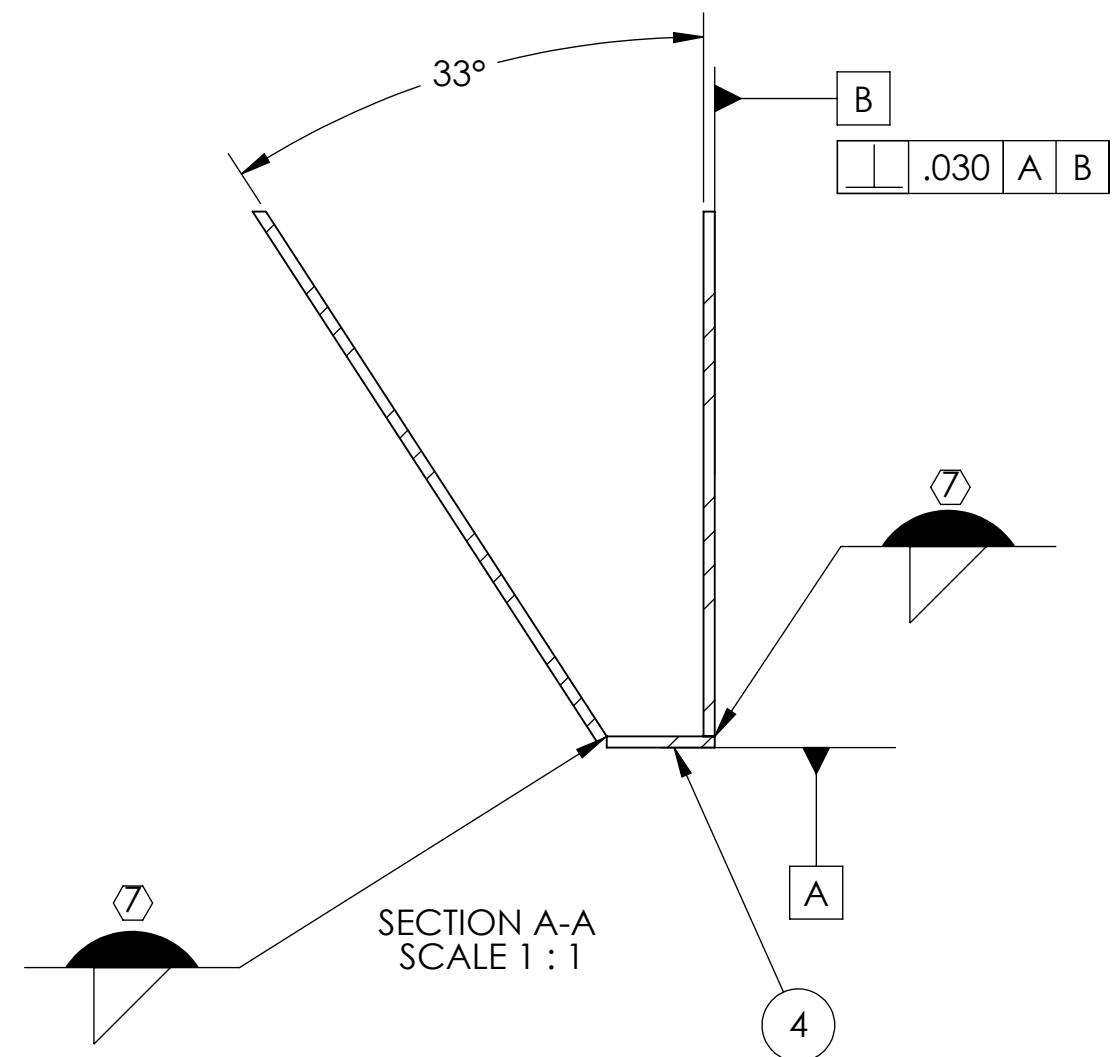
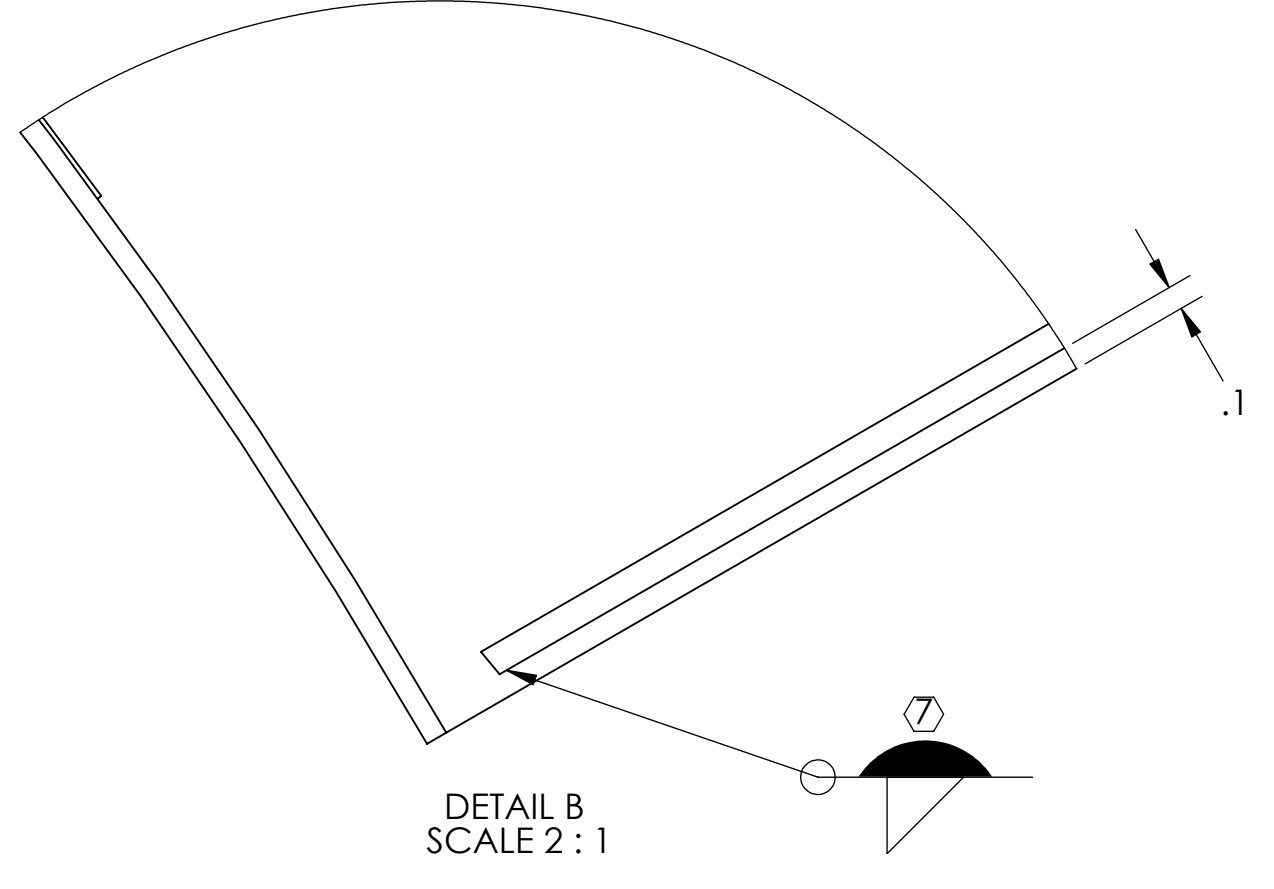
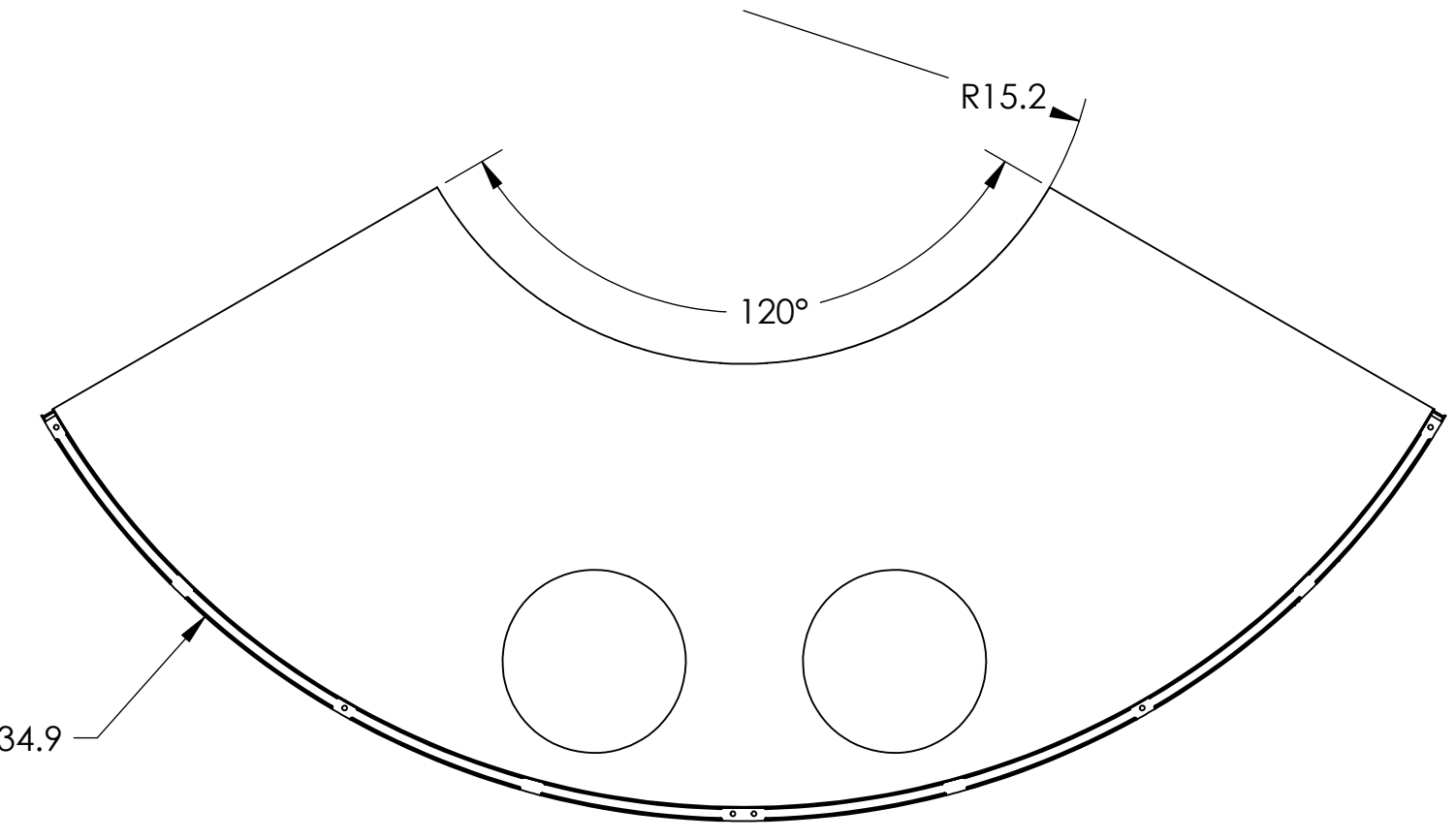
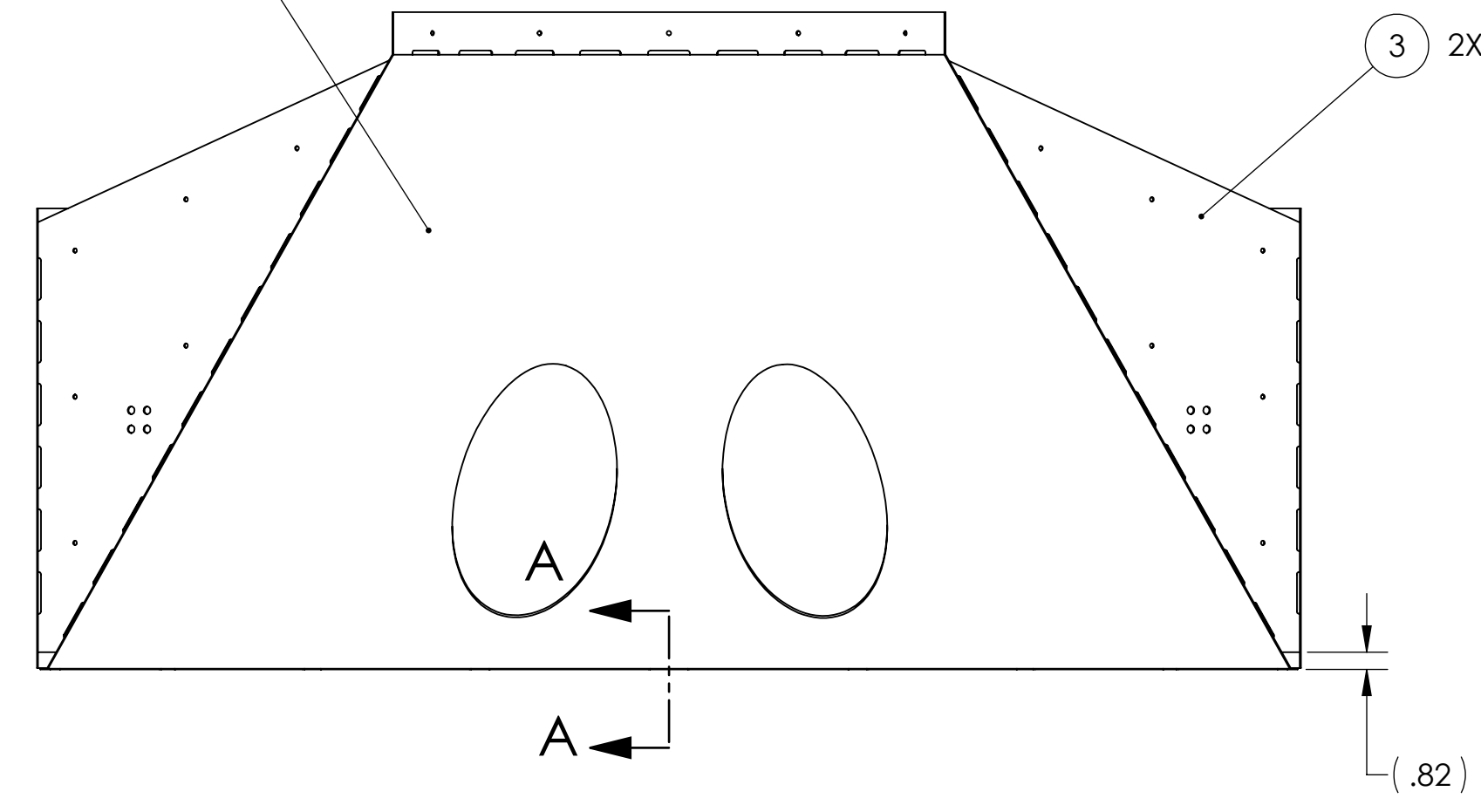
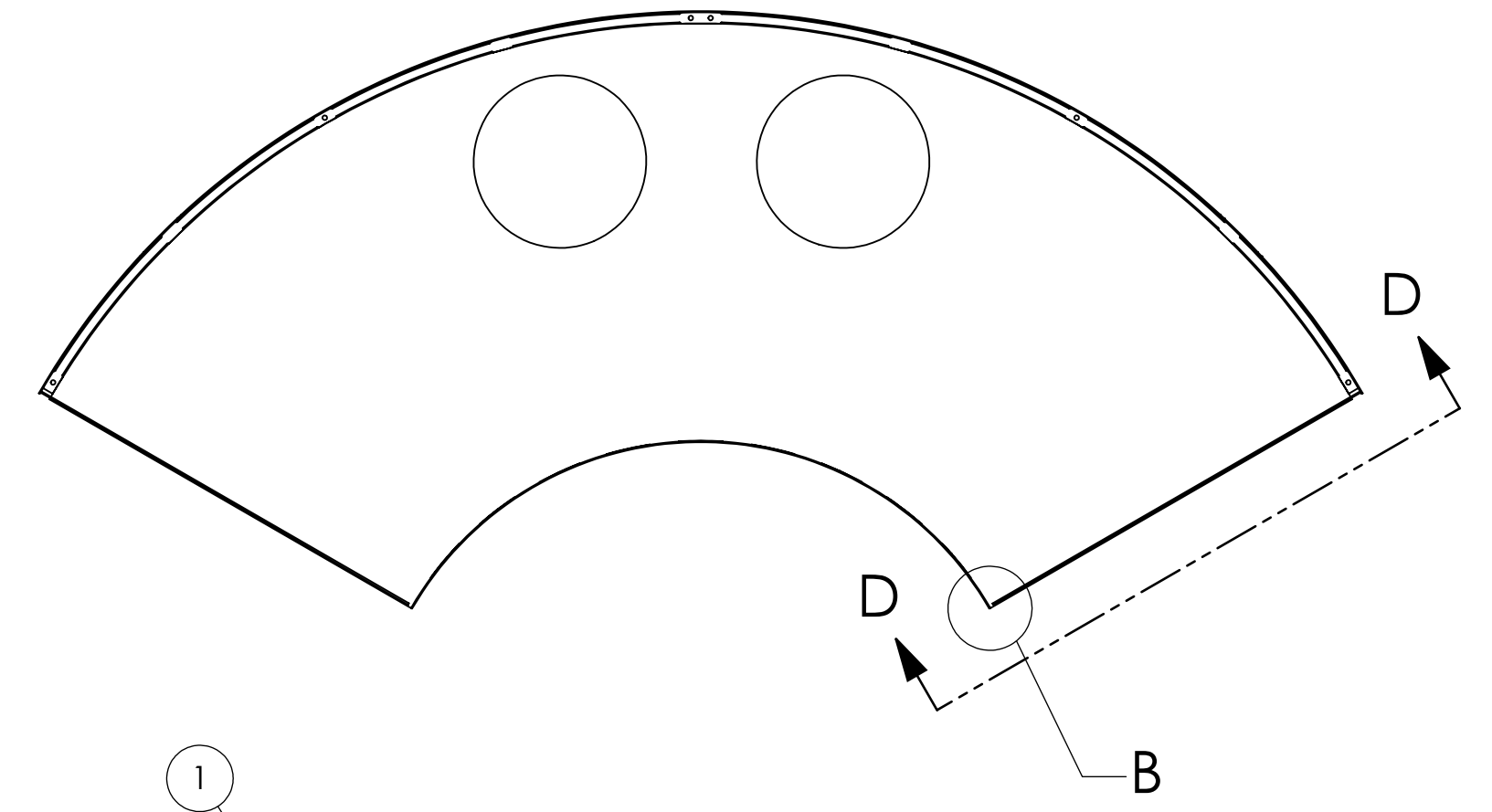
D0902654.dwg; Manifold_Cryo_Baffle_Segment_Subassembly_Weldment; ITMX H1-H2; Left; PART PDM REV: X:032; DRAWING PDM REV: X:010

REV.	DATE	DCN #	DRAWING TREE #
V1	17 MAR 2010	E1000360	E1000091
-	-	-	-
-	-	-	-

NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
 EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

6. ASSEMBLY TO BE PORCELAIN COATED AFTER WELDMENT IS COMPLETED PER SPECIFICATION E1000083

7. FILLET WELDS WHERE ITEMS 1 & 3, 1 & 5, & 1 & 4 MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14GA A424 TYPE I STEEL	1		1
3	D0902621	Manifold Cryo Baffle Bracket, Right	14GA A424 TYPE I STEEL	2		2
2	D0902620	RADIAL SEGMENT, BOTTOM	18GA A424 TYPE I STEEL	1		1
1	D0902623	MANIFOLD-CRYO BAFFLE INNER SEGMENT, ITMX H1-H2, BOTTOM	18GA A424 TYPE I STEEL	1		1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010	
ANGULAR ± 1.0°	
MATERIAL	FINISH
A424 TYPE I STEEL	N/A

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	
SYSTEM	SUB-SYSTEM
ADVANCED LIGO	AOS
NEXT ASSY	D0902061

PART NAME		MANIFOLD -CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ITMX H1-H2, BOTTOM	
DESIGNER	H. KELMAN	17 MAR 2010	SIZE DWG. NO.
DRAFTER	TQ. NGUYEN	003 SEP 2010	D
CHECKER	M. SMITH		D0902655
APPROVAL	D. COYNE		
SCALE:	1:8	PROJECTION:	
			SHEET 1 OF 1

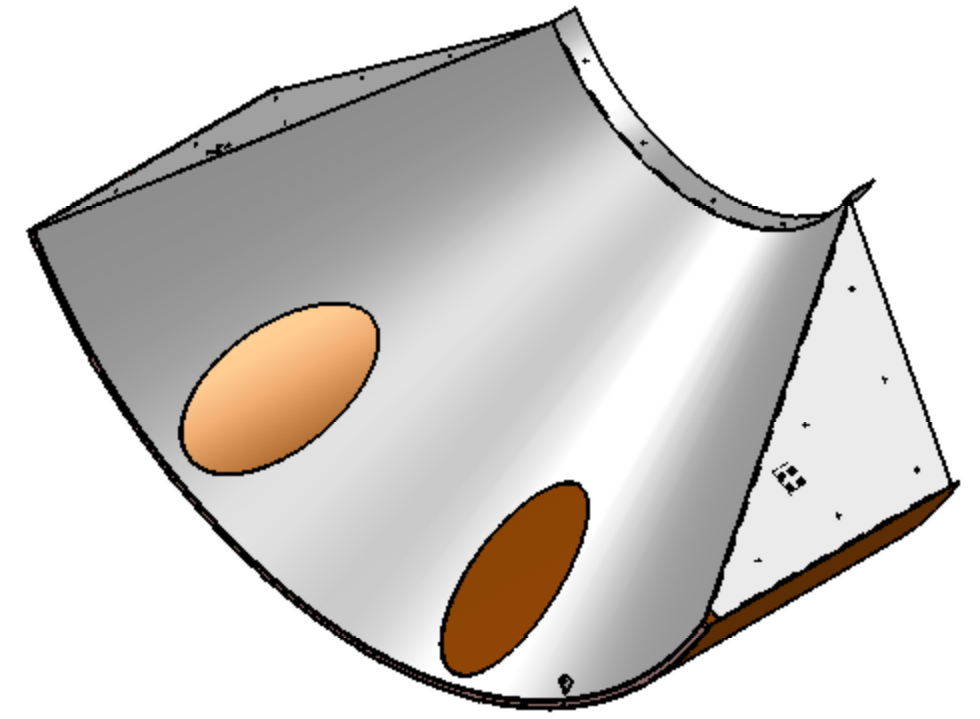
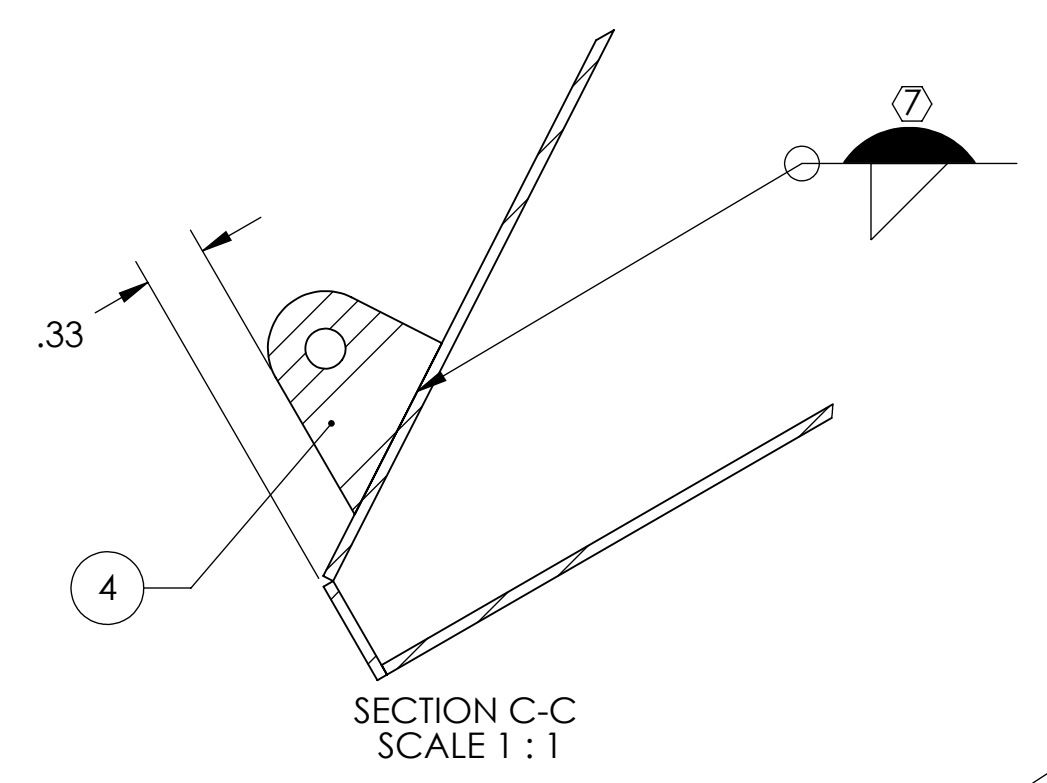
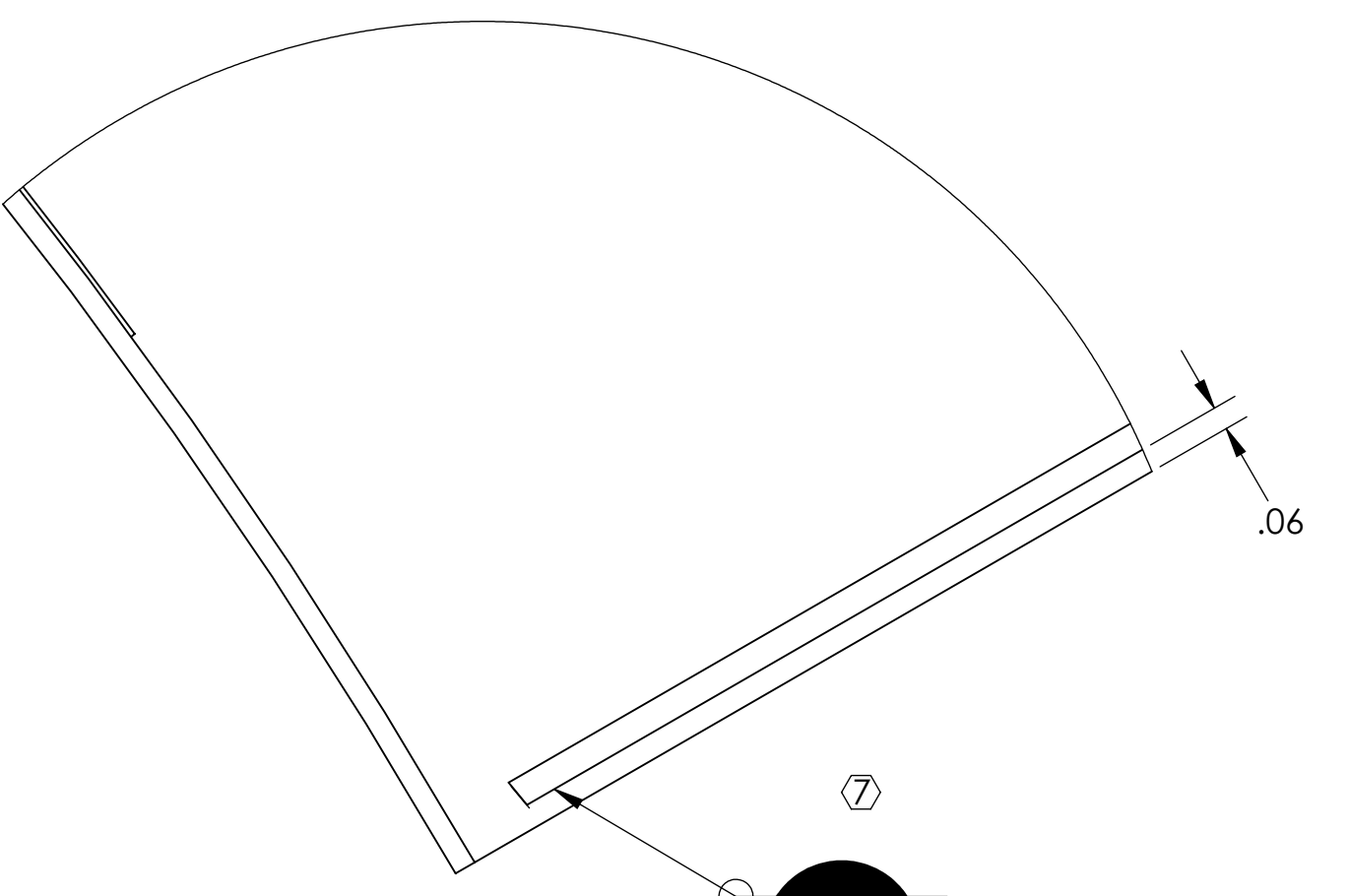
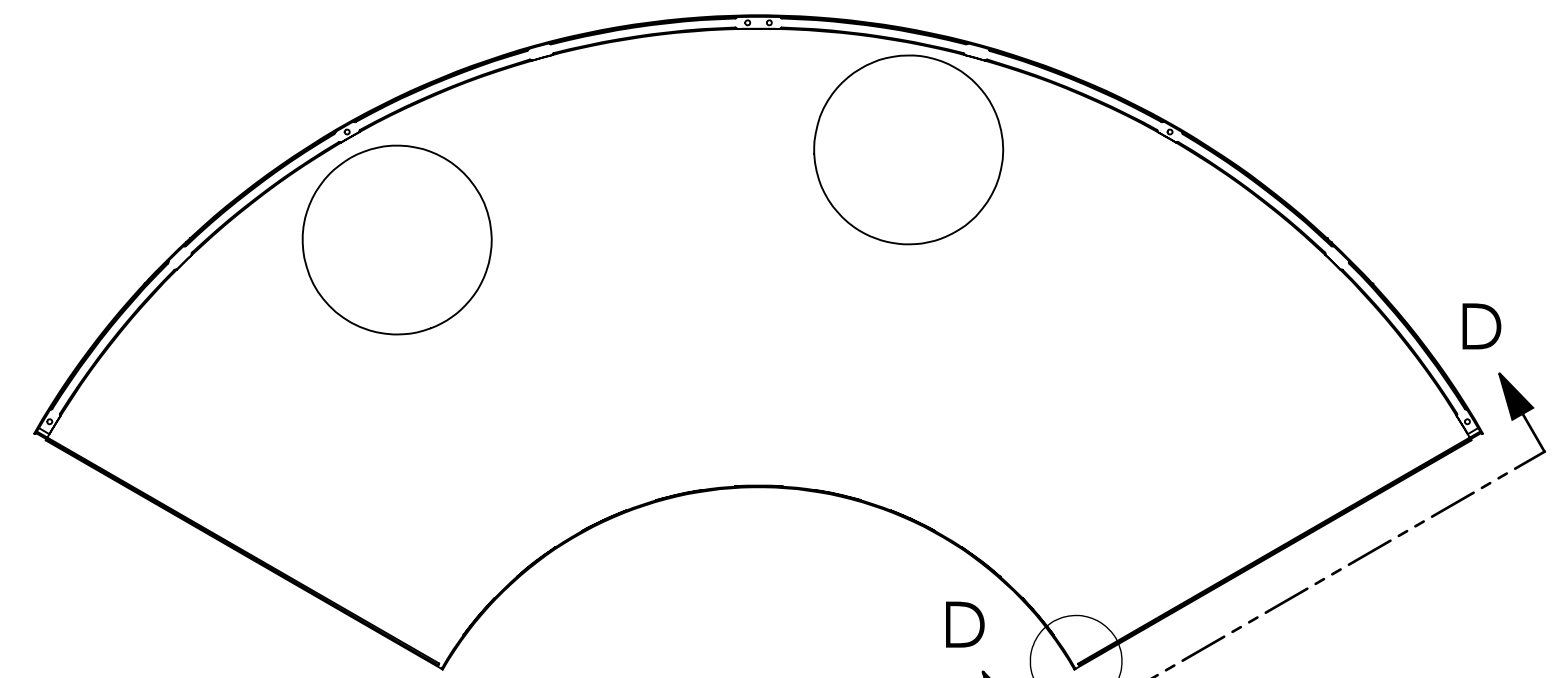
D0902655 at LIGO_Manifold_Cryo_Baffle_Segment_Subassembly_Weldment_ITMX_H1-H2_Bottom_PART_PDM_REV_X033_DRAWING_PDM_REV_X012

NOTES CONTINUED:
 5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER, SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED.
 EXAMPLE: DXXXXXX-VY, TYPE-XX, S/N XXX

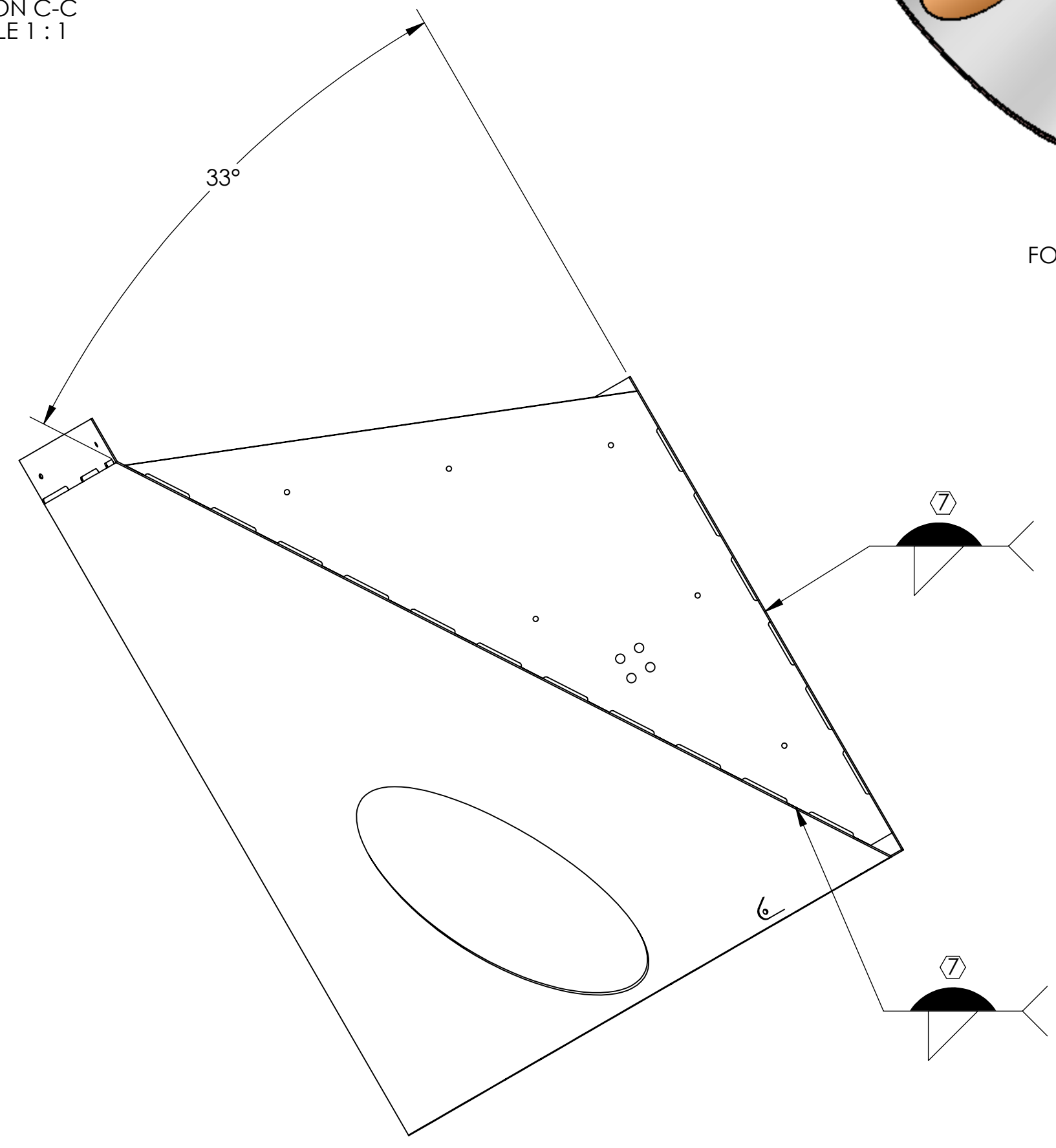
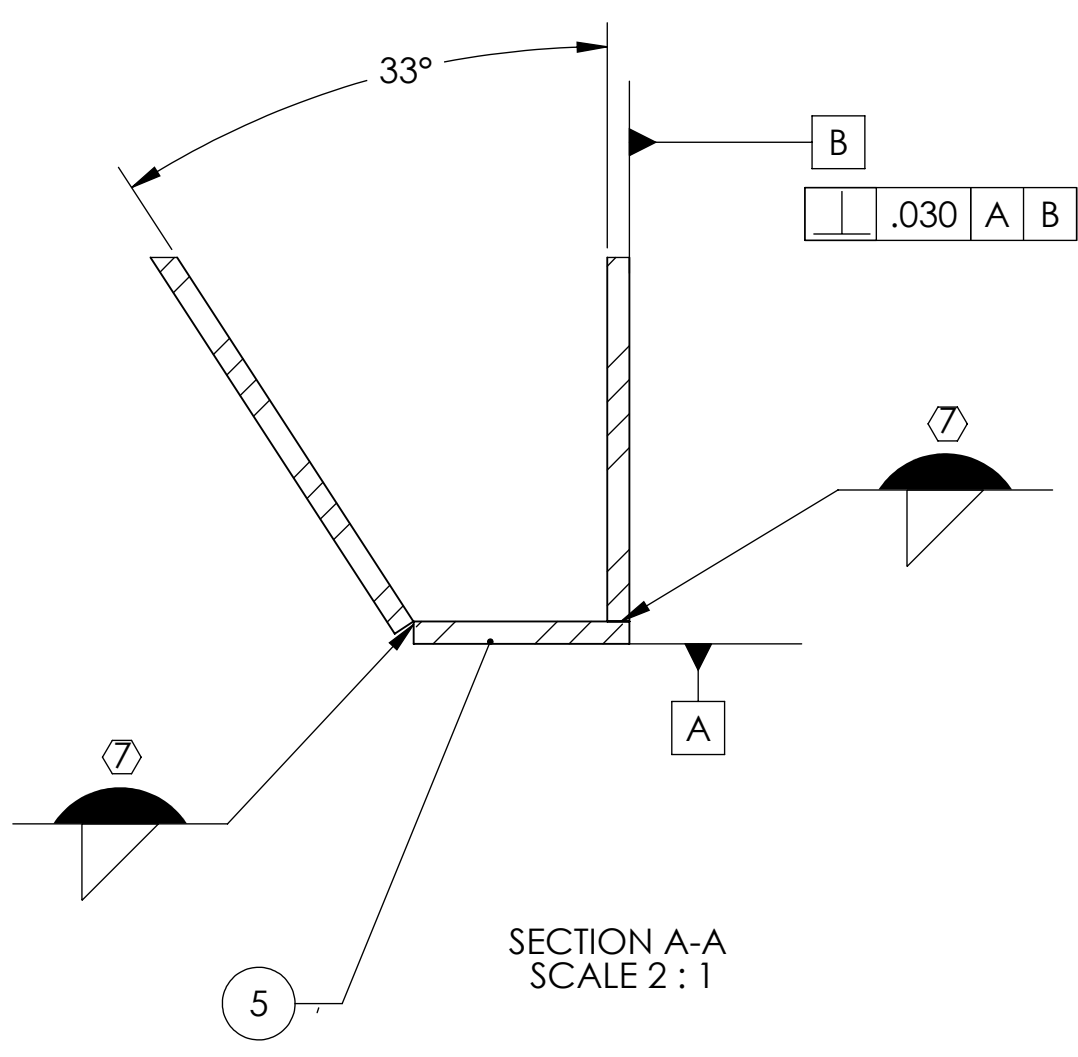
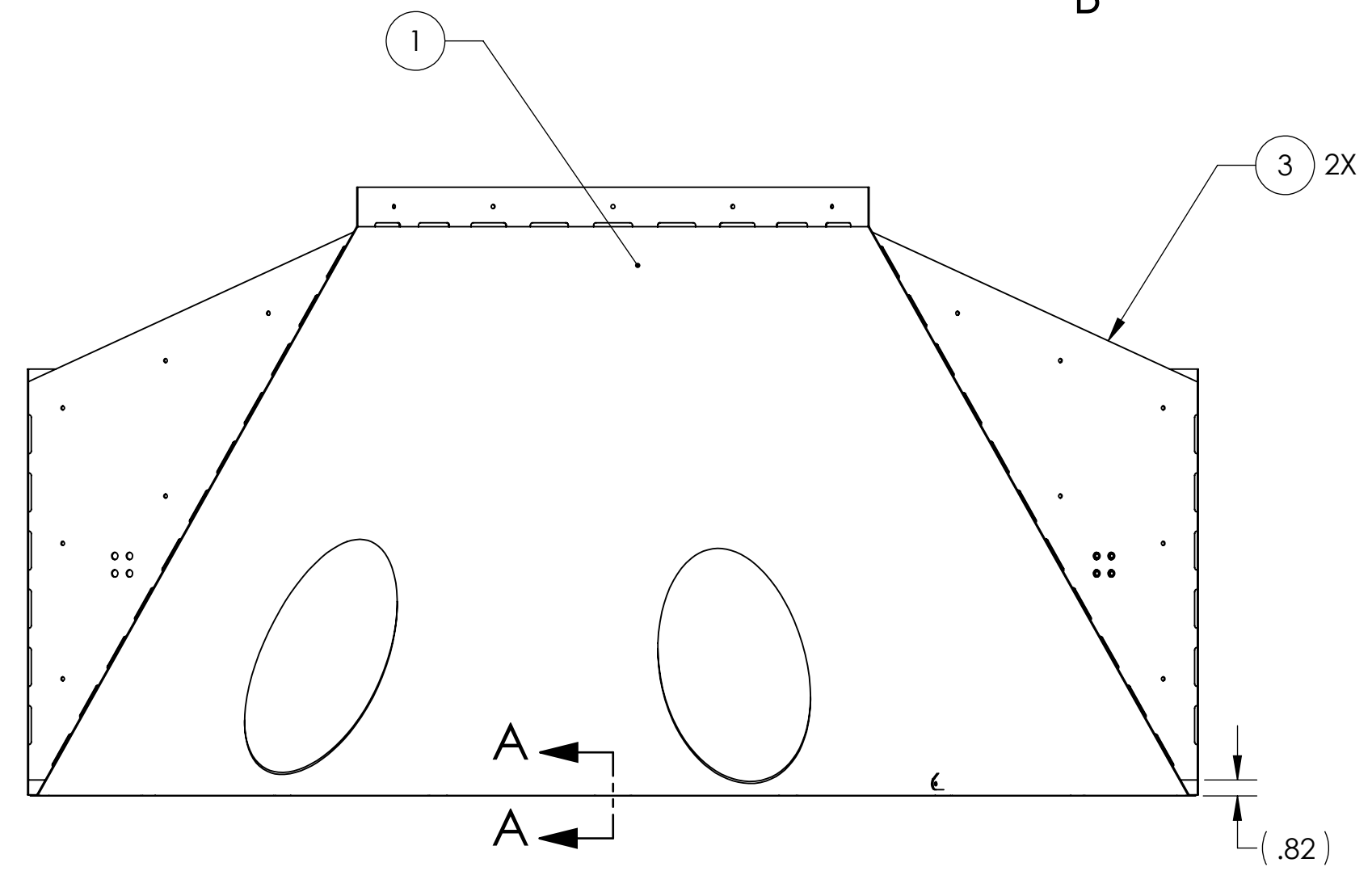
6. ASSEMBLY TO BE PORCELAIN COATED AFTER WELDMENT IS COMPLETED PER SPECIFICATION E1000083

7. FILLET WELDS WHERE ITEMS 1 & 3, 1 & 5, & 1 & 4 MAKE CONTACT. WELDING MUST BE PER SPECIFICATION E0900048

REV.	DATE	DCN #	DRAWING TREE #
v1	20 MAY 2010	E1000360	E1000091



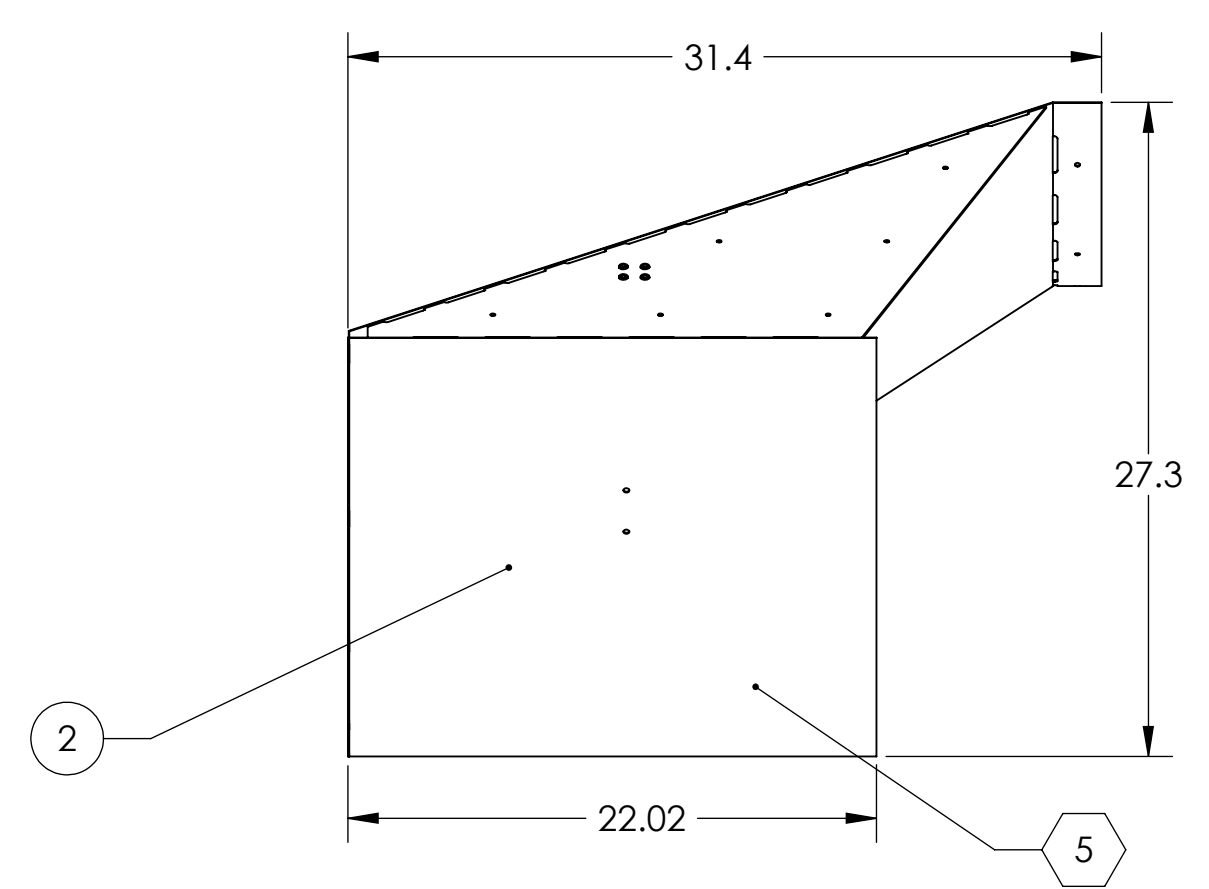
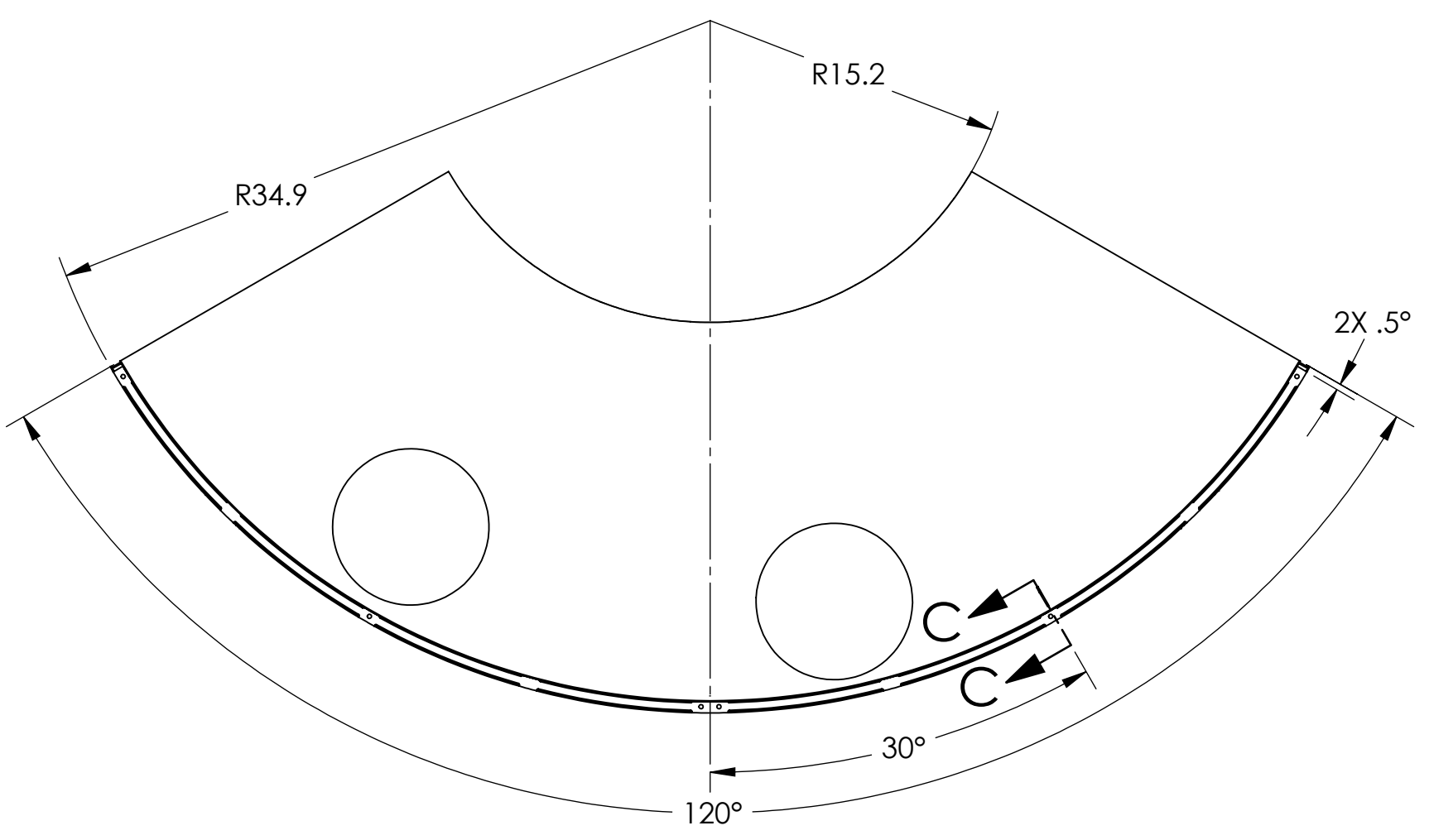
GENERAL VIEW FOR REFERENCE ONLY NO SCALE



SECTION D-D SCALE 1:5

7 PLS

12 PLS



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	QTY.	SPARE	TOTAL
5	D1000559	RADIAL SEGMENT, RIGHT	18GA A424 TYPE I STEEL	1		0
4	D1001073	RADIAL ATTACHMENT NUT PLATE	14GA A424 TYPE I STEEL	1		0
3	D1000536	Baffle Brace Bracket	14GA A424 TYPE I STEEL	1		0
2	D0902621	Manifold Cryo Baffle Bracket, Right	14GA A424 TYPE I STEEL	2		0
1	D0902619	MANIFOLD-CRYO BAFFLE INNER SEGMENT WELDMENT, ITMX H1-H2, RIGHT	18GA A424 TYPE I STEEL	1		0

DIMENSIONS ARE IN INCHES	
TOLERANCES:	.X ± .1
	.XX ± .06
	.XXX ± .010
ANGULAR ±	1.0°

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
1.	INTERPRET DRAWING PER ASME Y14.5-1994.
2.	REMOVE ALL SHARP EDGES, R.02 MIN.
3.	DO NOT SCALE FROM DRAWING.
4.	ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.
MATERIAL	N/A
FINISH	(8)

LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY
 MASSACHUSETTS INSTITUTE OF TECHNOLOGY

SYSTEM: **ADVANCED LIGO** SUB-SYSTEM: **AOS**

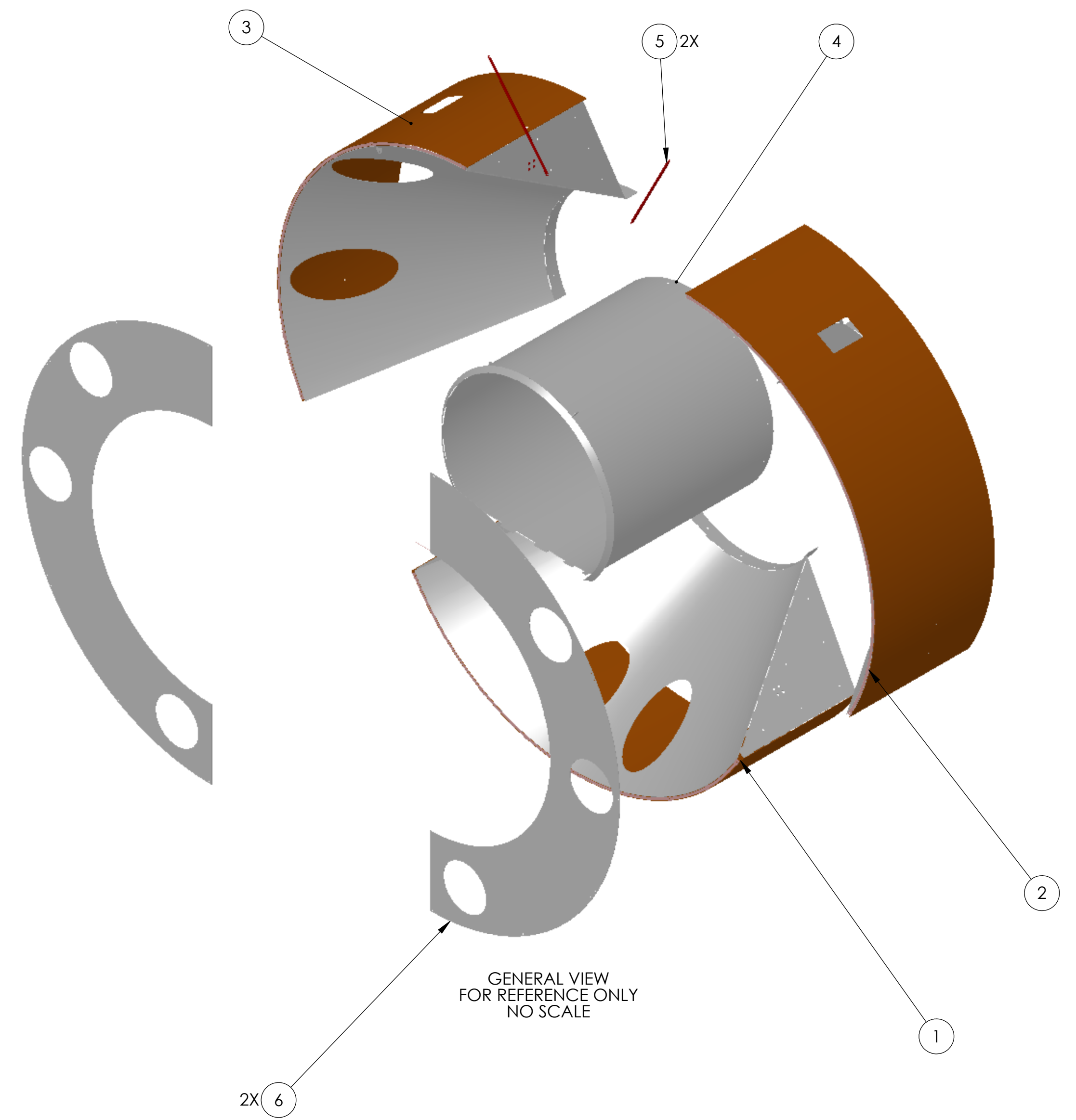
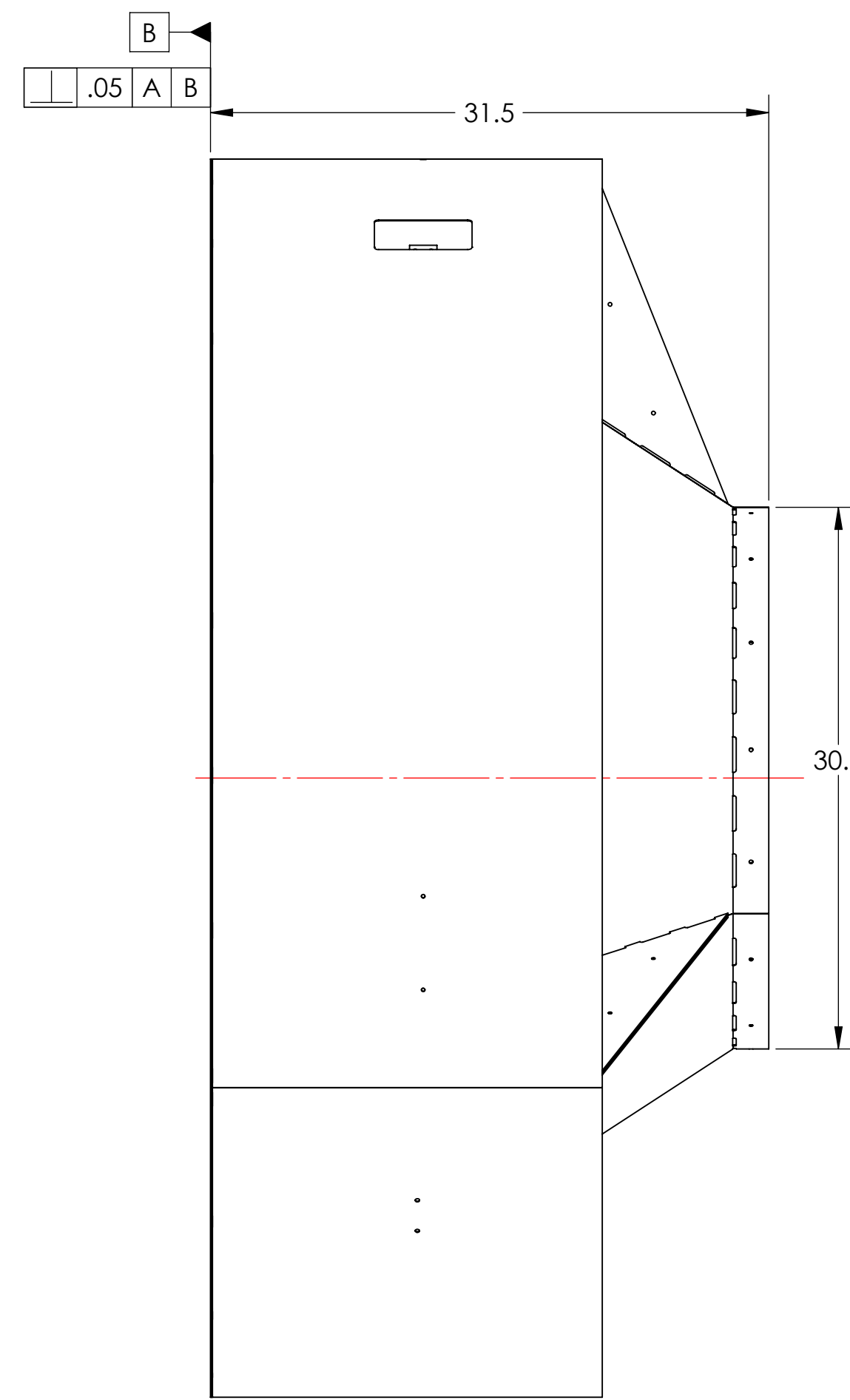
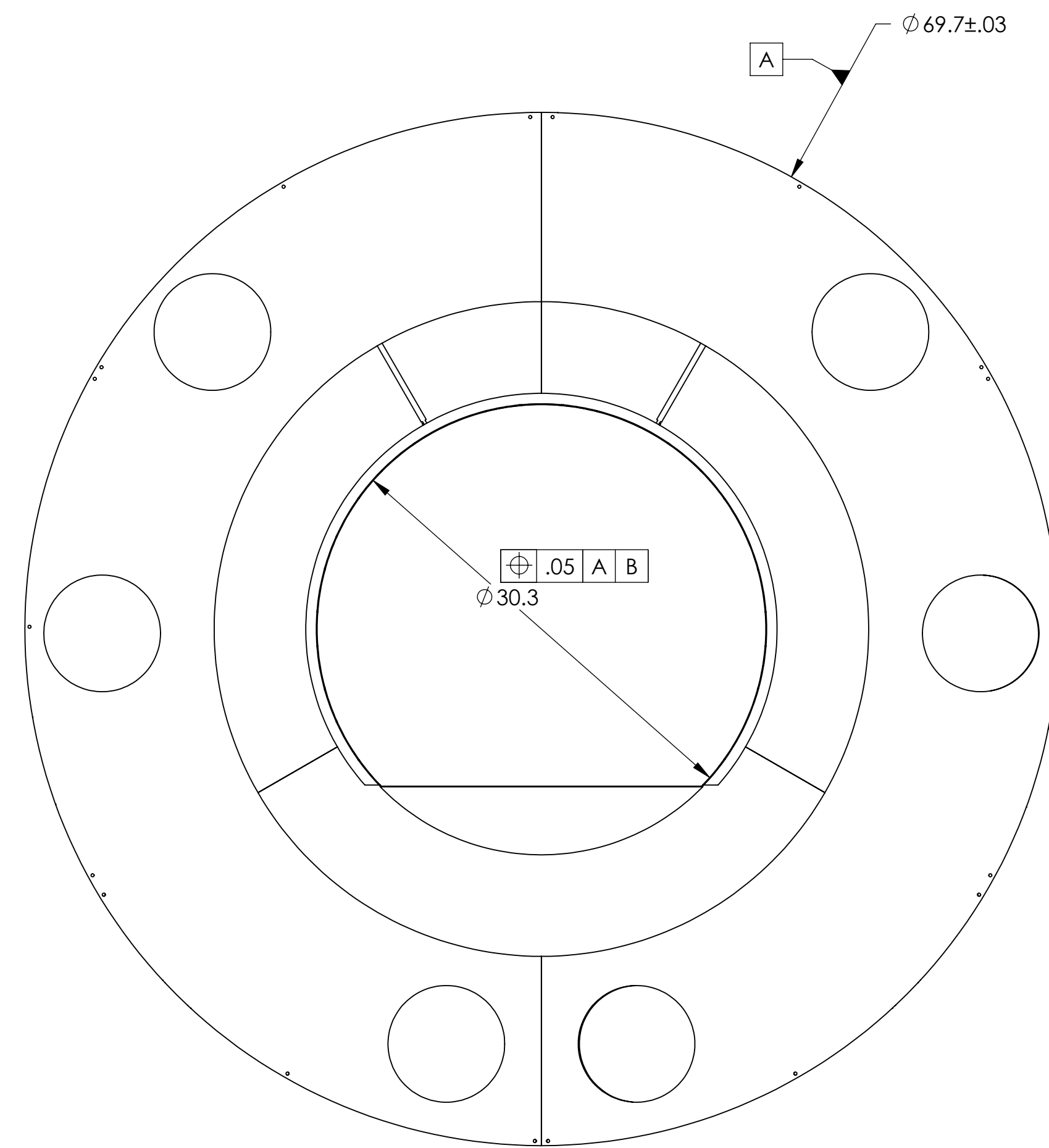
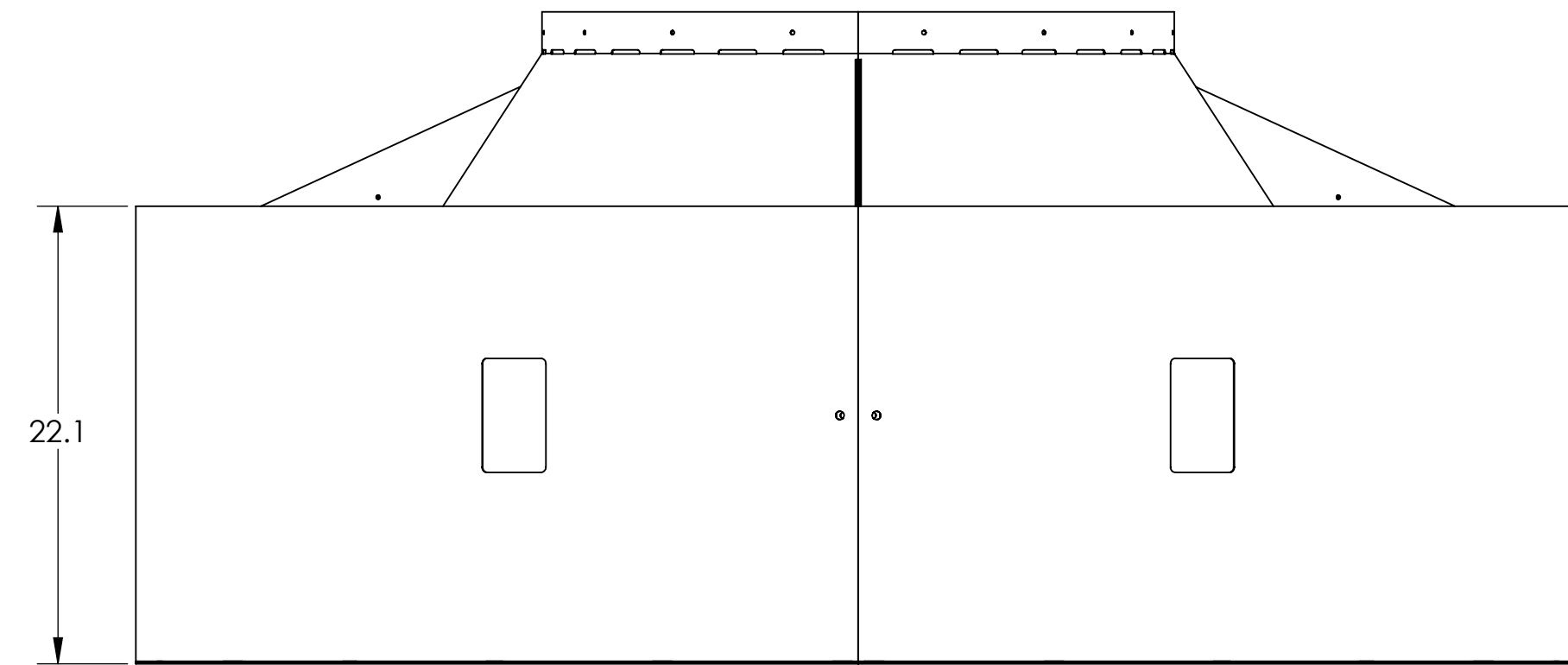
NEXT ASSY: **D0902061**

PARTS LIST		PART NAME	
MANIFOLD CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMENT, ITMX H1-H2, RIGHT		DESIGNER	H. KELMAN
DATE	20 MAY 2010	CHECKER	TG. NGUYEN
DATE	07 SEP 2010	CHECKER	M. SMITH
DATE		APPROVAL	D. COYNE
SIZE	D	DWG. NO.	D0902654
REV.	v1	SCALE	1:8
		PROJECTION	
		SHEET	1 OF 1

D:\0202654\atUGO_Manifold_Cryo_Baffle_Segment_Subassembly_Weldment_ITMX_H1-H2_Right_PARR_PDM_REV.X-007.DRAWING.PDM REV: X-007

NOTES CONTINUED:
5. ASSEMBLY TO BE PERFORMED BY LIGO STAFF.

REV.	DATE	DCN #	DRAWING TREE #
V1	08 SEP 2010	E1000360	E1000185
-	-	-	-
-	-	-	-



ITEM NO.	PART NUMBER	DESCRIPTION	MATERIAL	REQ	SPARE	TOTAL
6	D0902657	MANIFOLD-CRYO BAFFLE HALF FACE PLATE, ITMX H1-H2	18GA A424 TYPE I STEEL	2		2
5	D1000572	MANIFOLD-CRYO BAFFLE BRACE	304, 316 OR 302 SSSL	2		2
4	D1001348	MANIFOLD-CRYO BAFFLE CYLINDER-SCRAPER ASSEMBLY	N/A	1		1
3	D0902656	MANIFOLD-CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMNT, ITMX H1-H2, LEFT	N/A	1		1
2	D0902654	MANIFOLD CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMNT, ITMX H1-H2, RIGHT	N/A	1		1
1	D0902655	MANIFOLD-CRYO BAFFLE SEGMENT SUBASSEMBLY WELDMNT, ITMX H1-H2, BOTTOM	N/A	1		1

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)	
DIMENSIONS ARE IN INCHES	
TOLERANCES: .X ± .1 .XX ± .06 .XXX ± .010	
ANGULAR ± 1.0°	
MATERIAL	N/A
FINISH	N/A μinch

CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME WELDMNT ASSY	
SYSTEM ADVANCED LIGO	SUB-SYSTEM AOS	DESIGNER H. KELMAN	SIZE DWG. NO. D 1002061
CHECKER M. SMITH	APPROVAL D. COYNE	DATE 18 AUG 2010	REV. v1
SCALE: 1:12		PROJECTION:	
ITEM NO. D0902617		SHEET 1 OF 1	

D1002061_dLIGO_AOS_Manifold-Cryo Baffle_Rotidial Segment Assy_PART_PDM_REV-X-020_DRAWING_PDM_REV-X-008